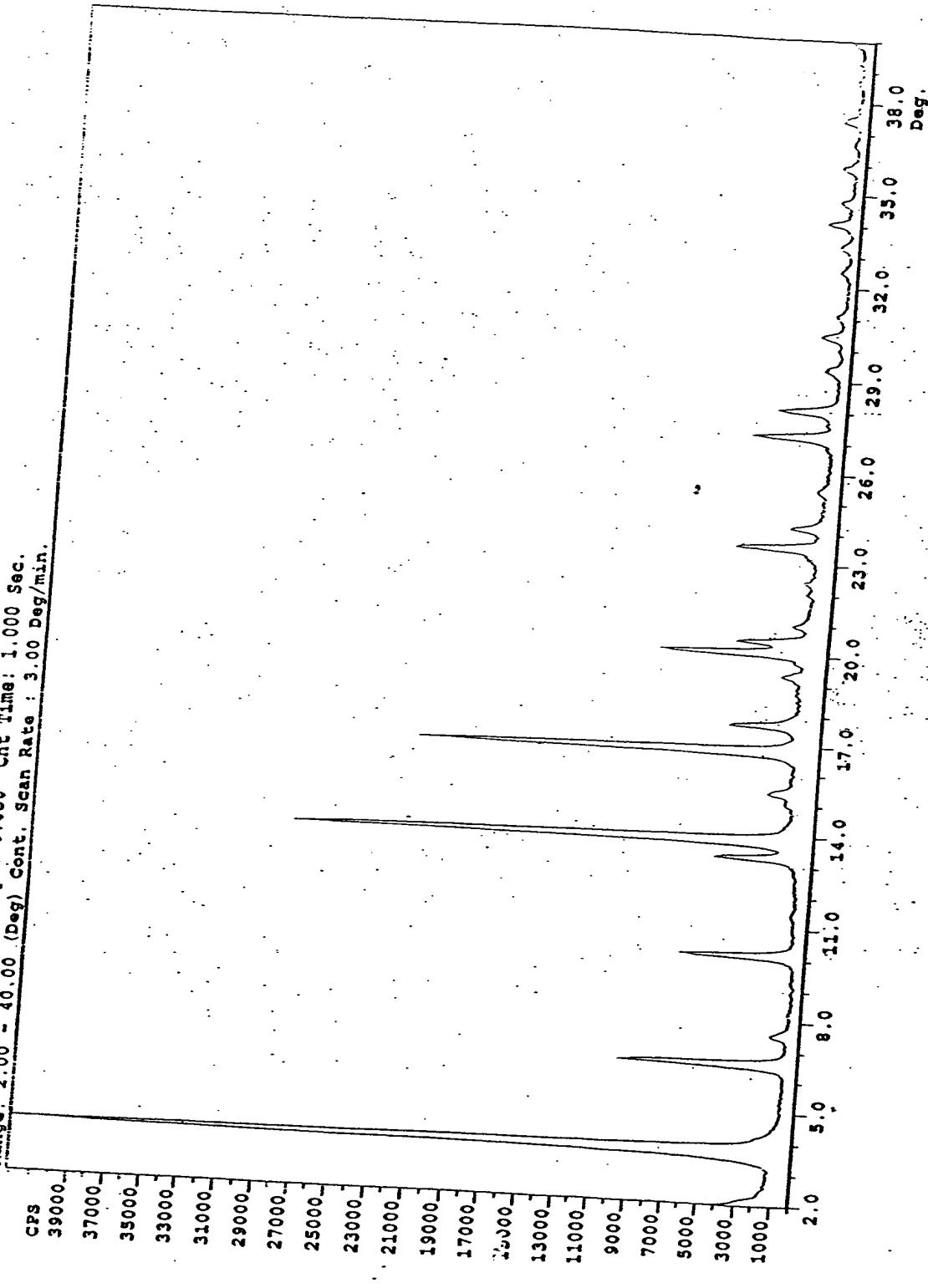


Fig 1

A

Range: 2.00 - 40.00 (Deg) Cnt Time: 1.000 Sec.  
Stop : 0.030 (Deg) Cont. Scan Rate : 3.00 Deg/min.



⑧

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Fig. 2 C

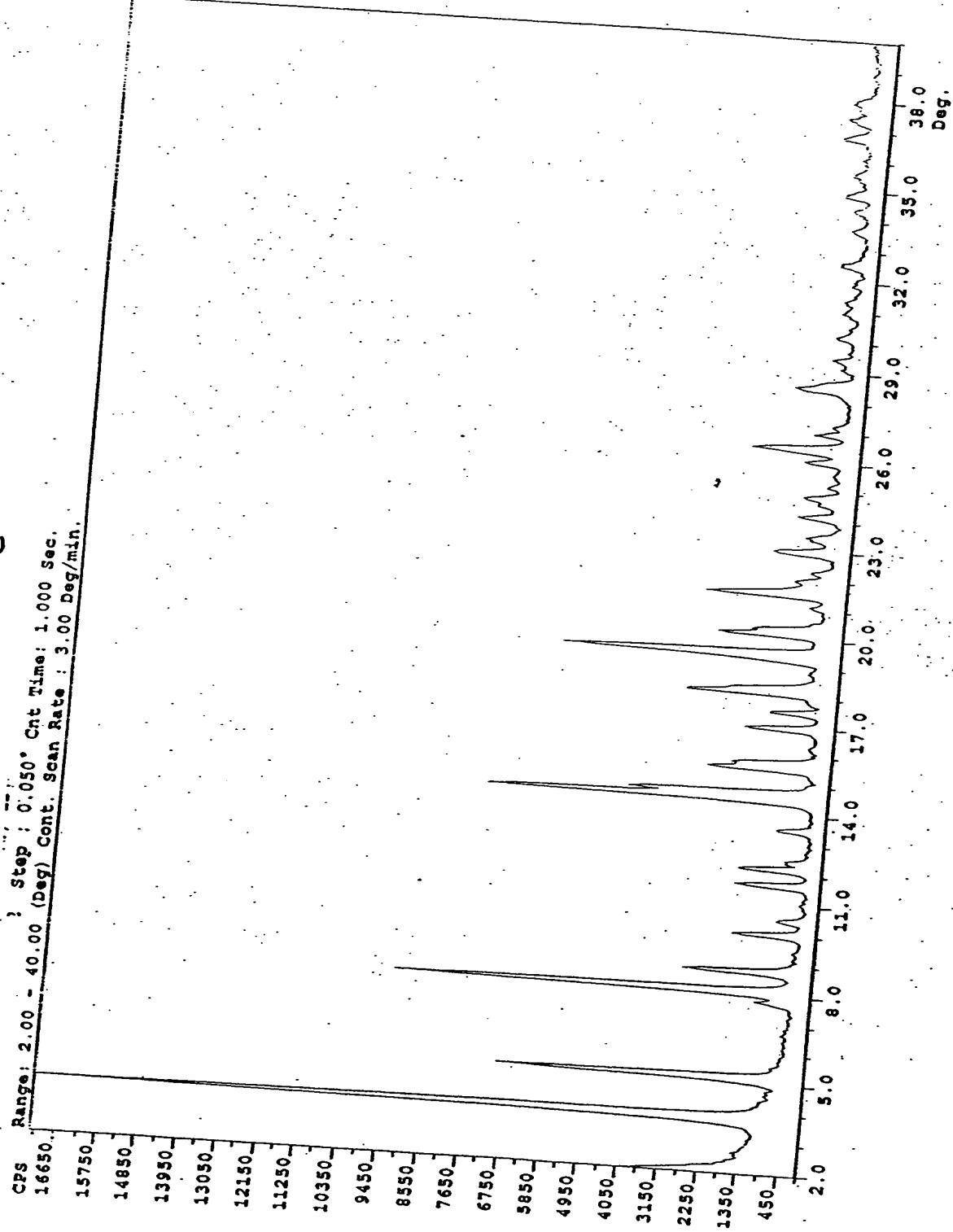


Fig 3 D

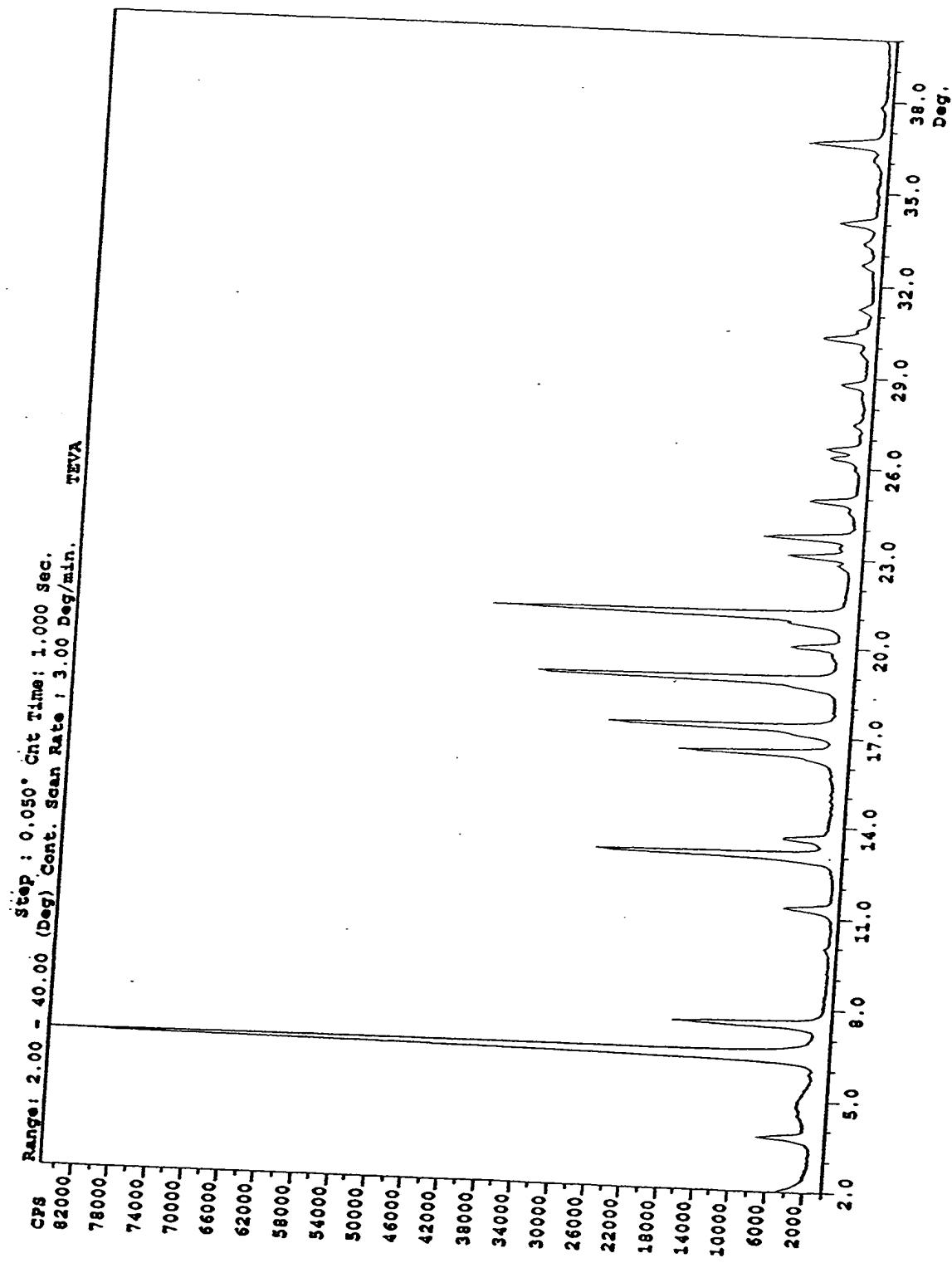


fig 4 E

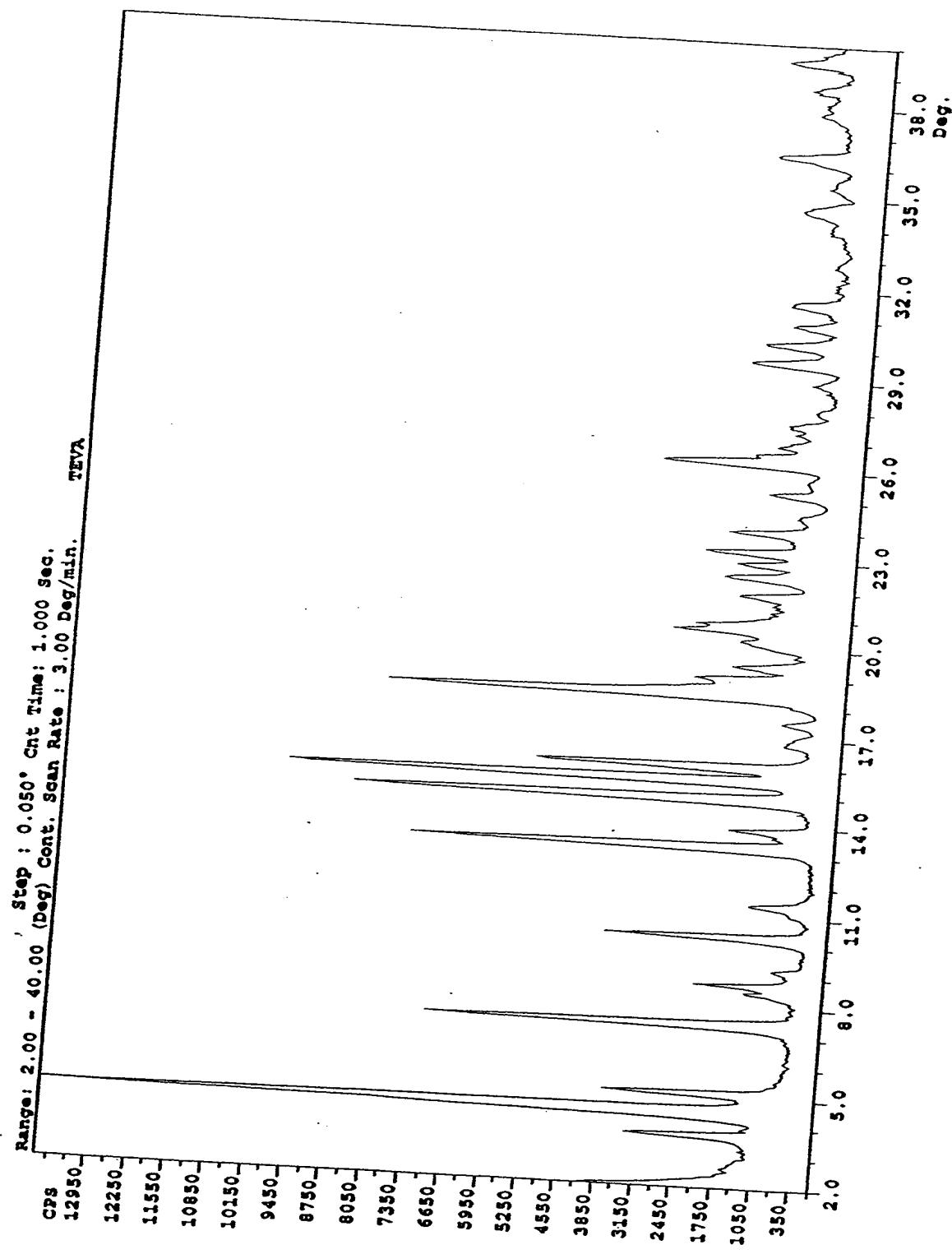


Fig. 5

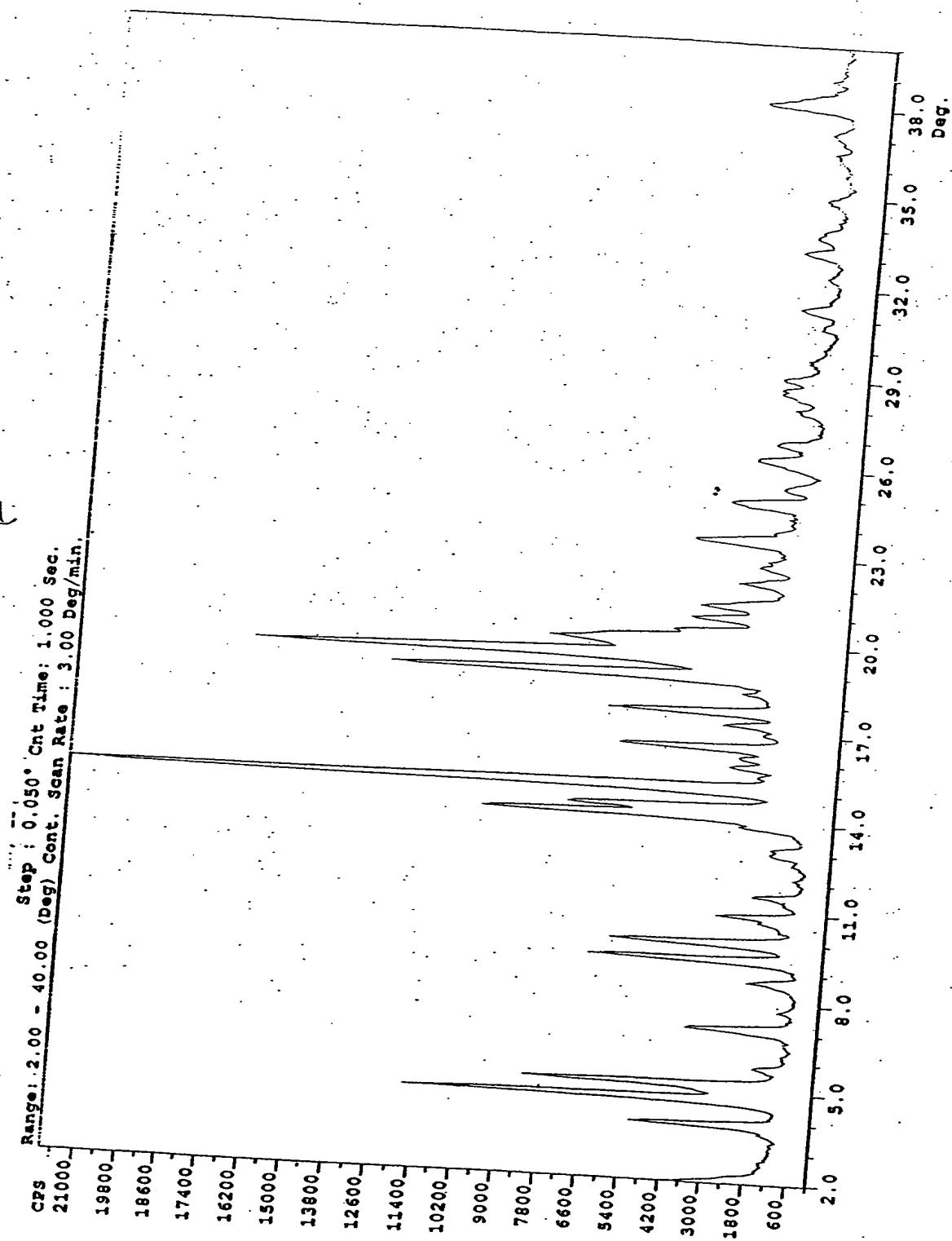


Fig. 6

G

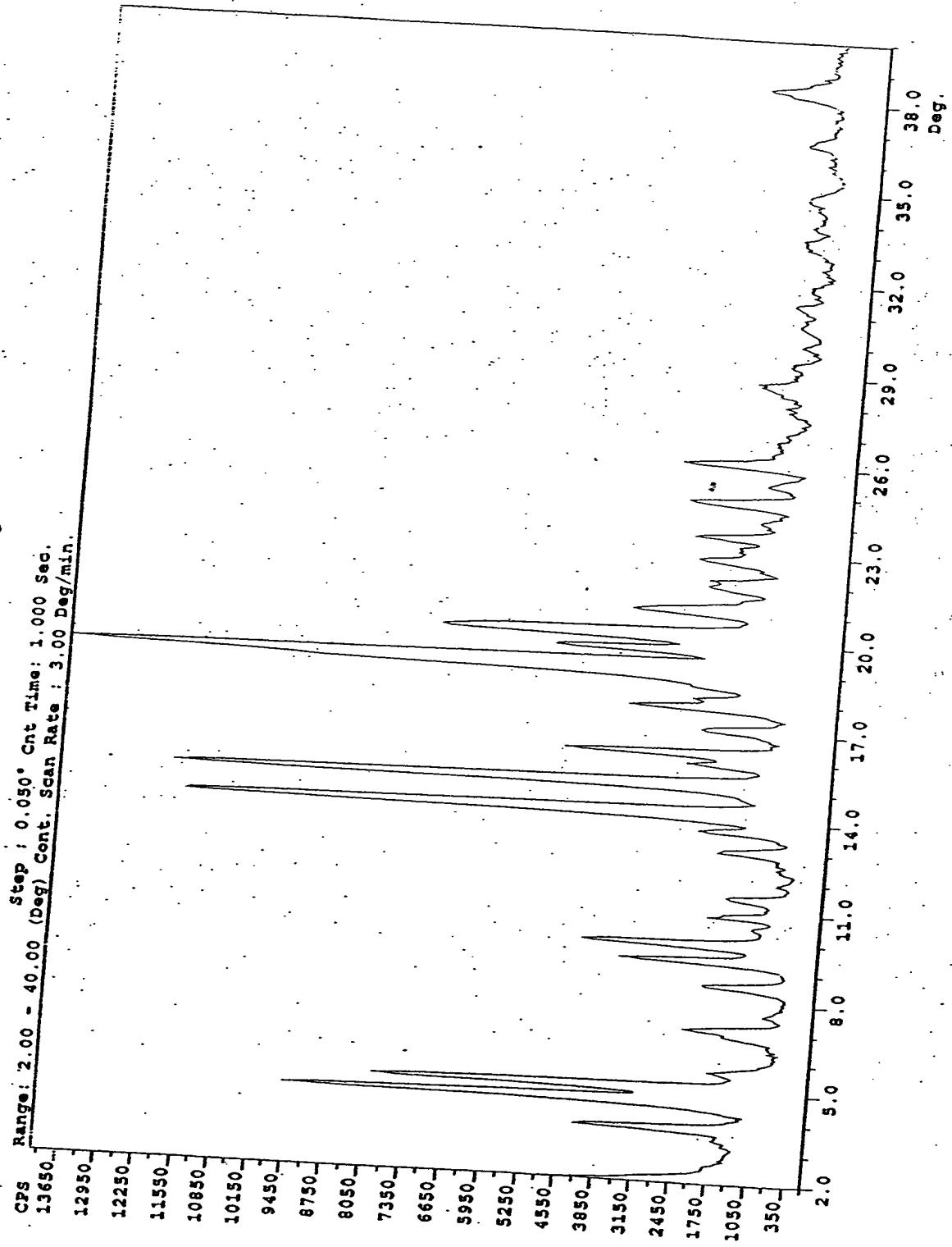


Fig. 7

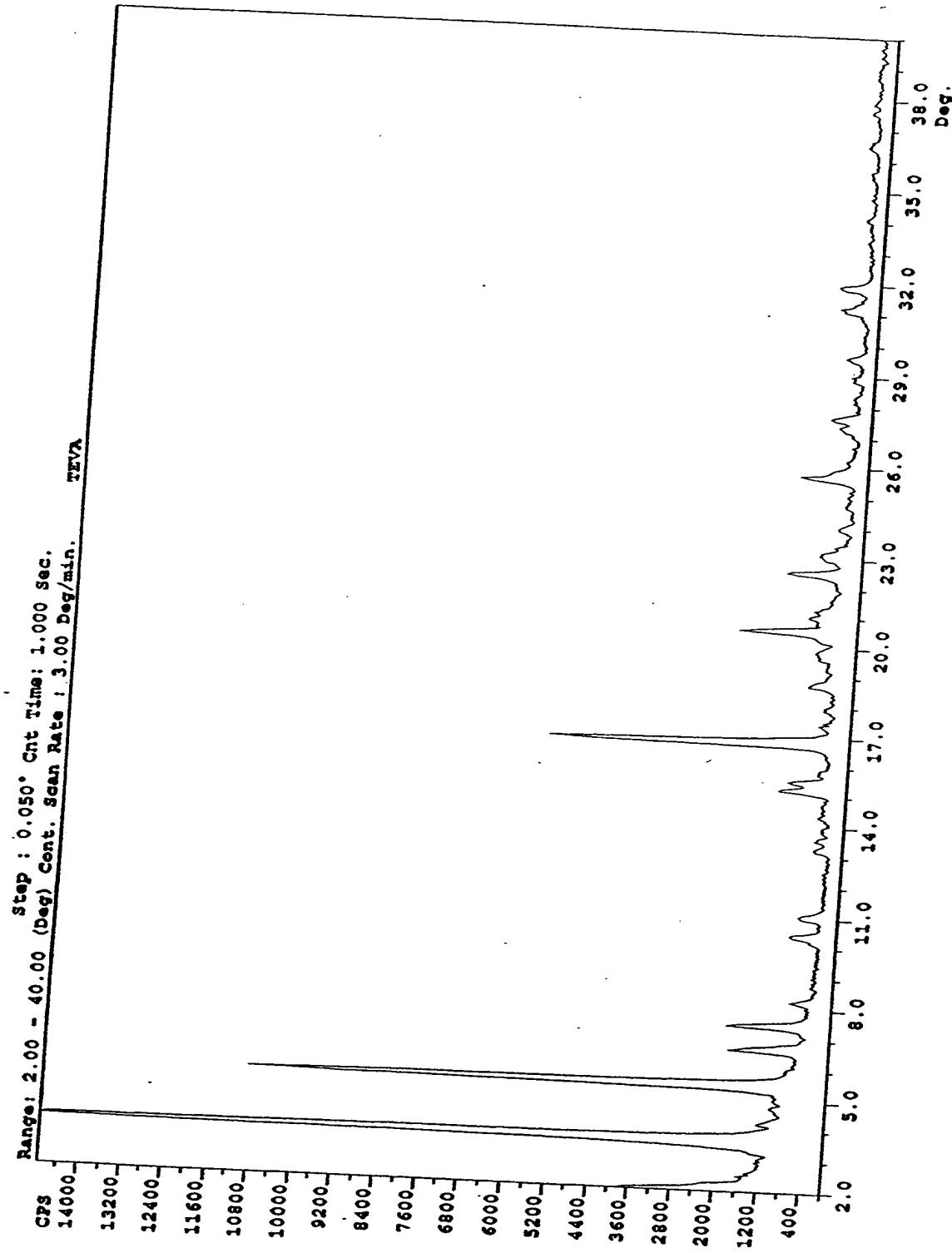


Fig. 8

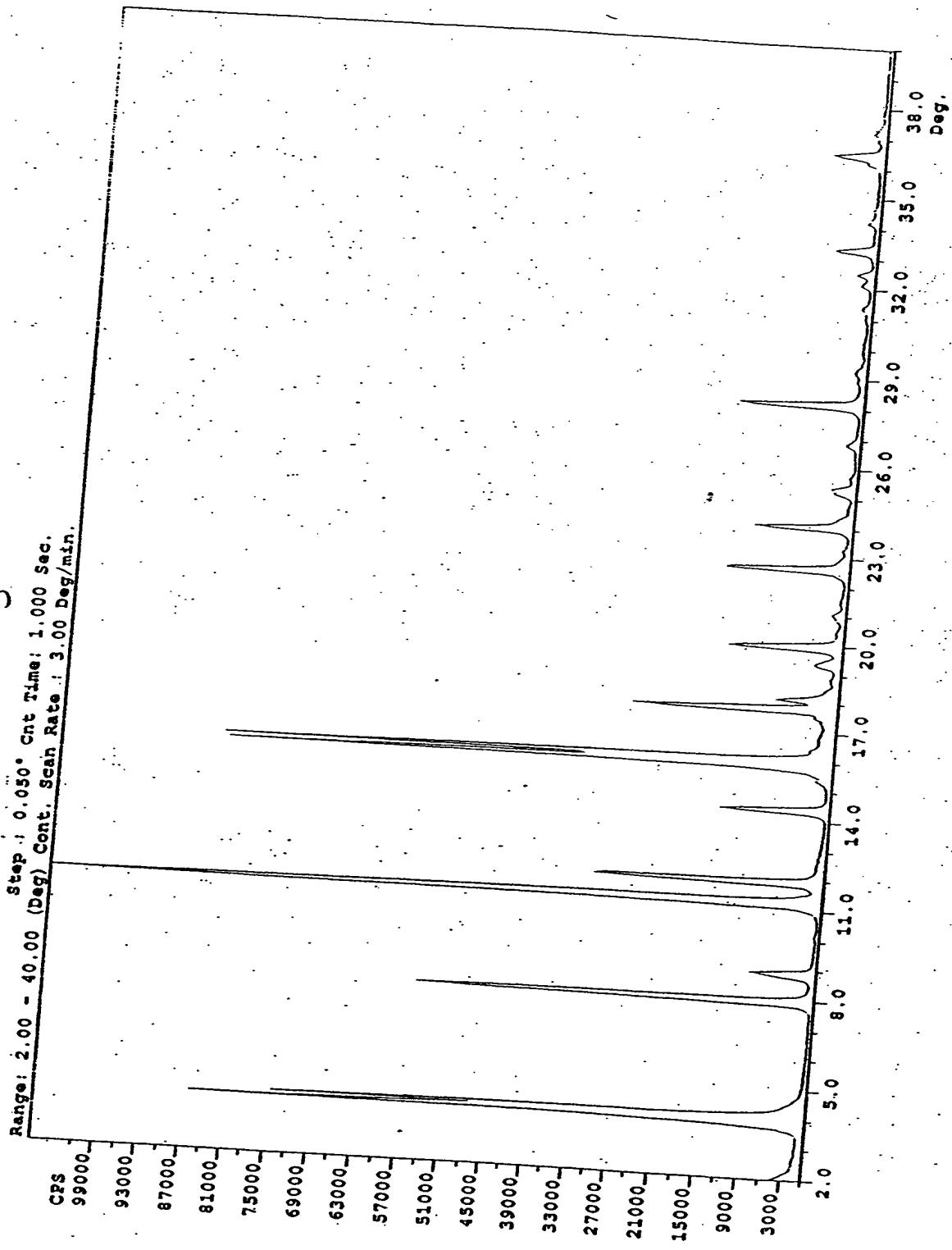


Fig. 9

K

CPS  
Range: 2.00 - 40.00 (Deg.)  
Step : 0.050° Cnt Time: 1.000 Sec.  
27300  
25900  
24500  
23100  
21700  
20300  
18900  
17500  
16100  
14700  
13300  
11900  
10500  
9100  
7700  
6300  
4900  
3500  
2100  
700

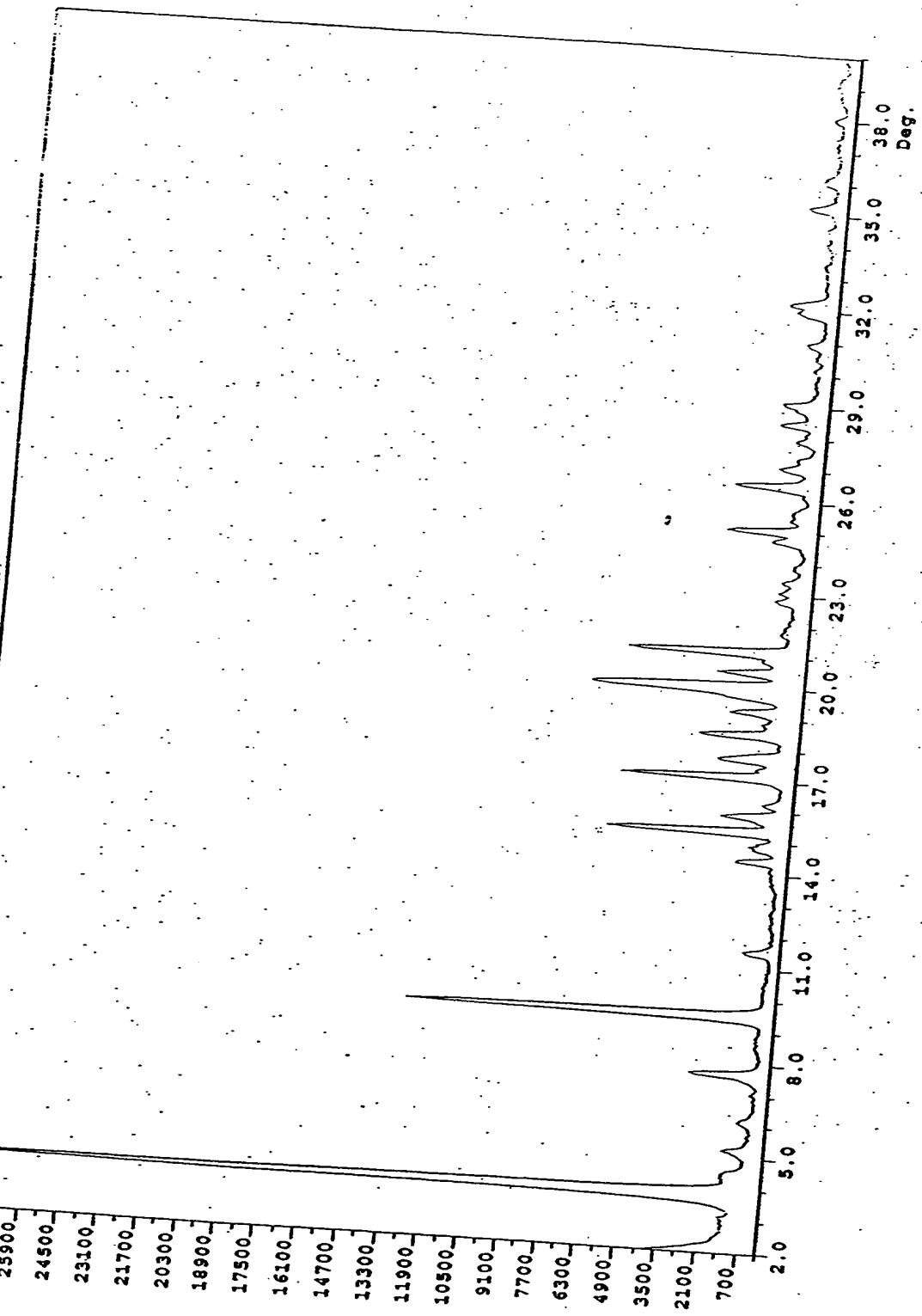
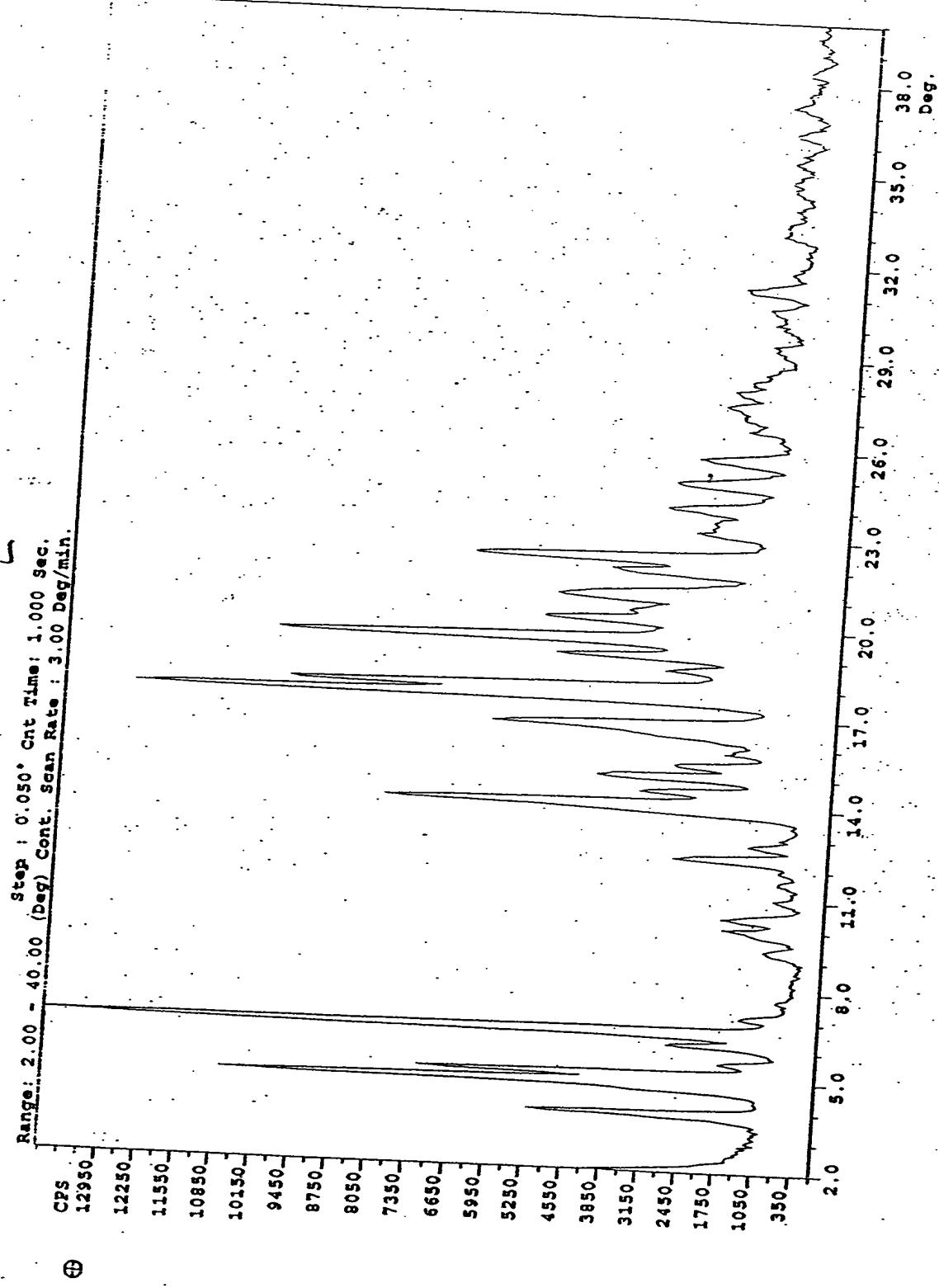


Fig. 10 L



679.41

Range: 2.00 - 40.00. Step: 0.050. Cnt Time: 1.000 SEC.  
CPS 7000  
6600  
6200  
5800  
5400  
5000  
4600  
4200  
3800  
3400  
3000  
2600  
2200  
1800  
1400  
1000  
600  
200

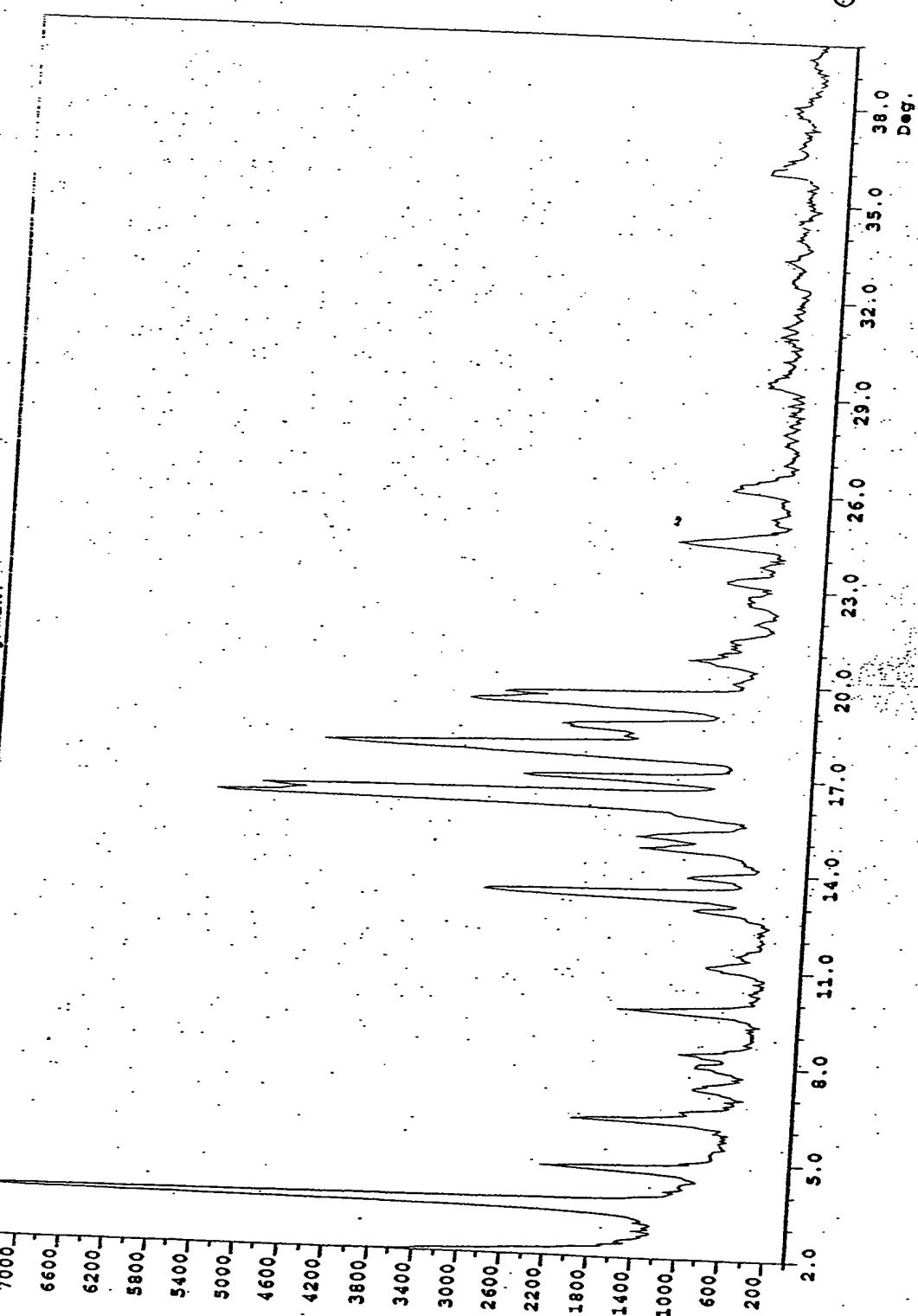


Fig. 12

Range: 2.00 - 40.00 (Deg) Cont. Scan Rate: 3.00 Deg/min.

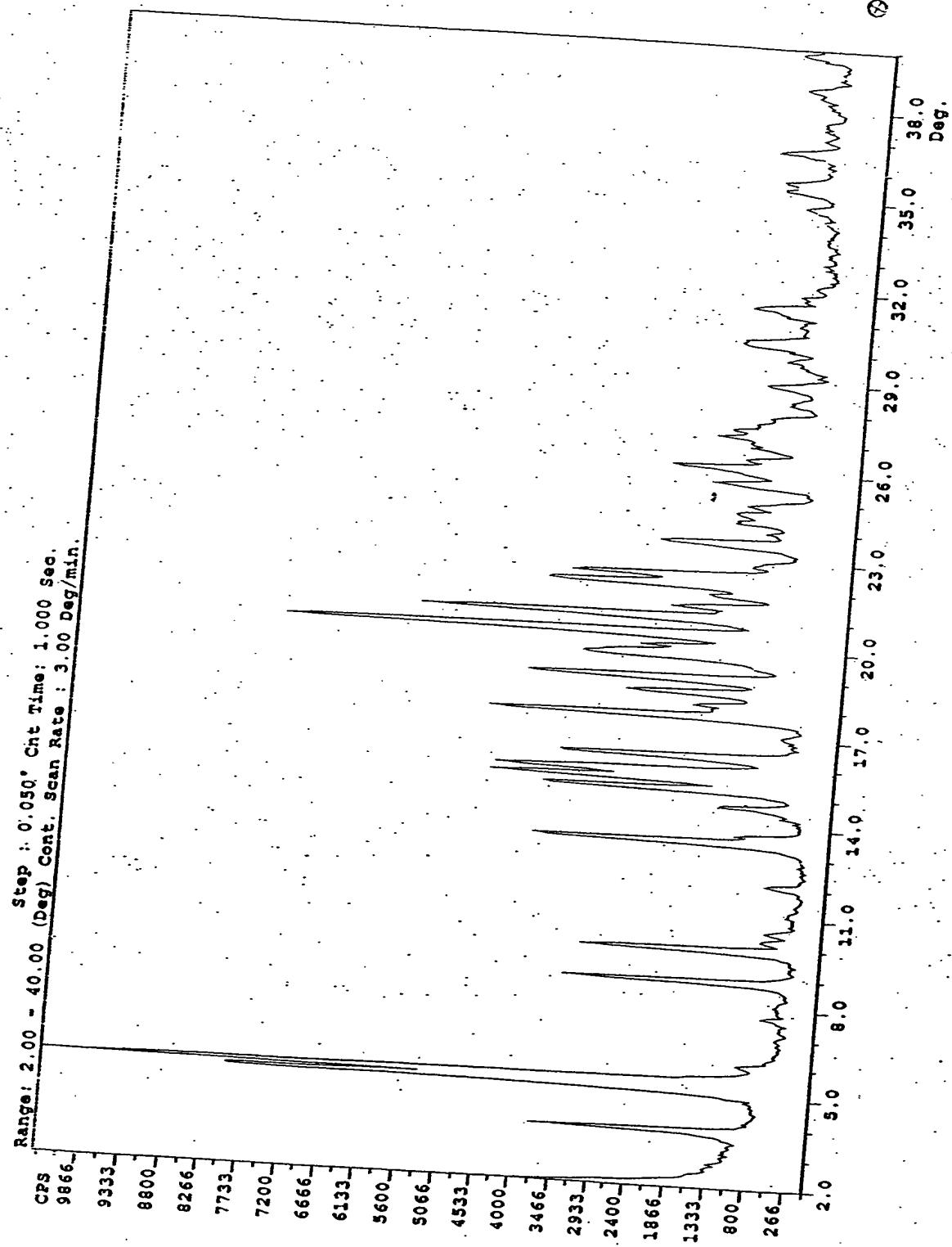


Fig. 13

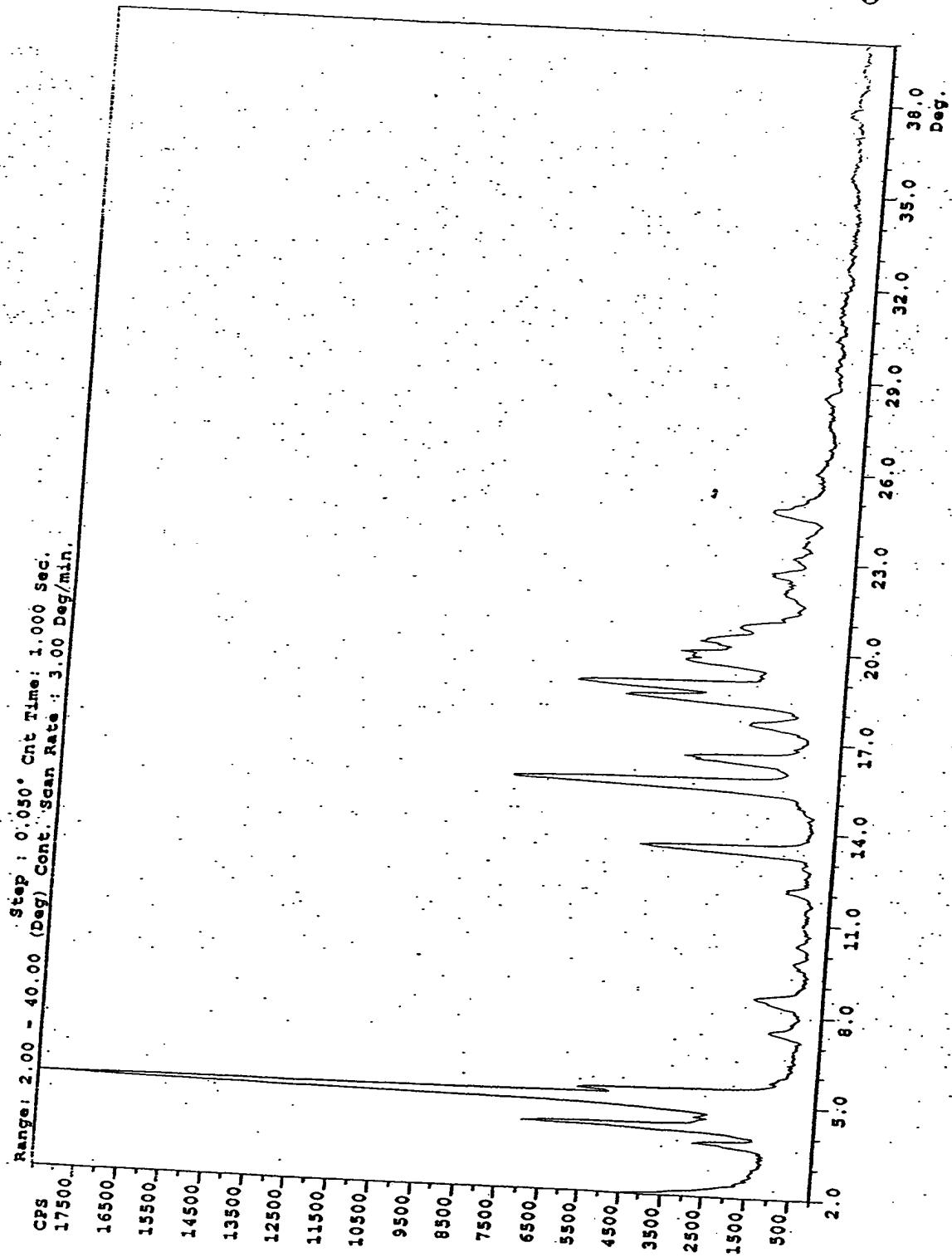


Fig. 14

P

Range: 2.00 - 40.00 (Deg) Cont. Scan Time: 1.000 Sec.  
Step: 0.050 (Deg) Scan Rate: 3.00 Deg/min.

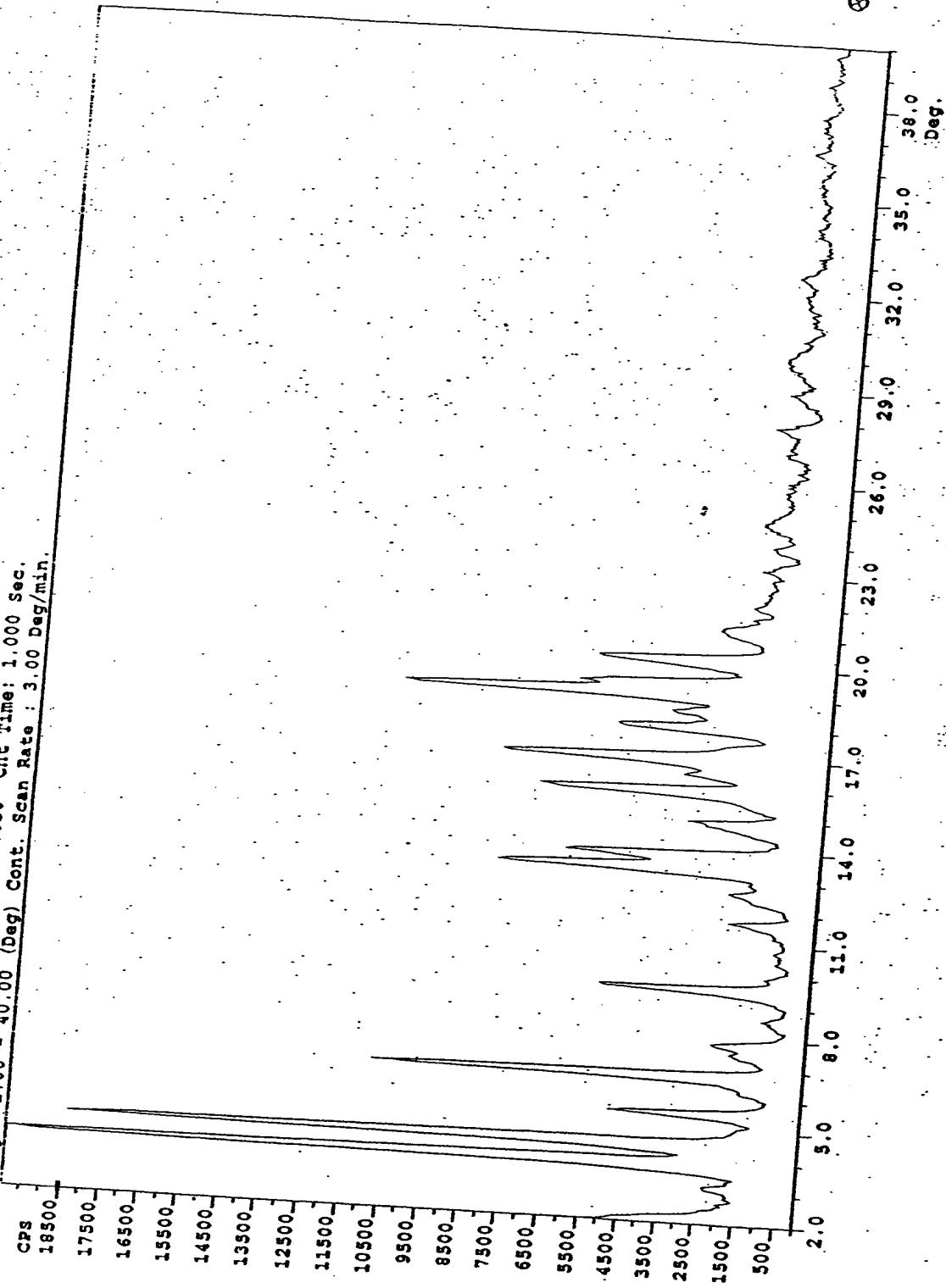
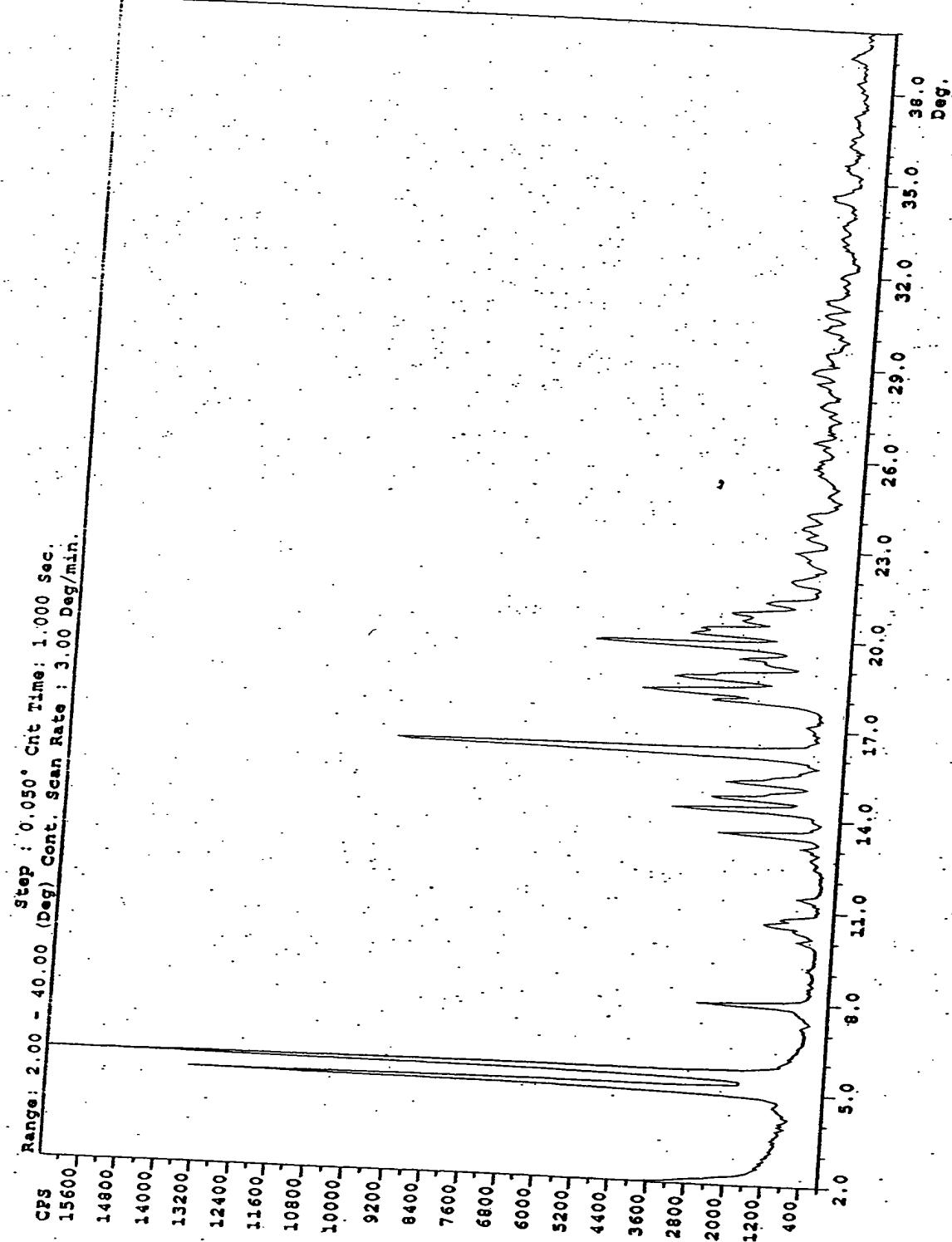


Fig. 15

Q



4, J. 16

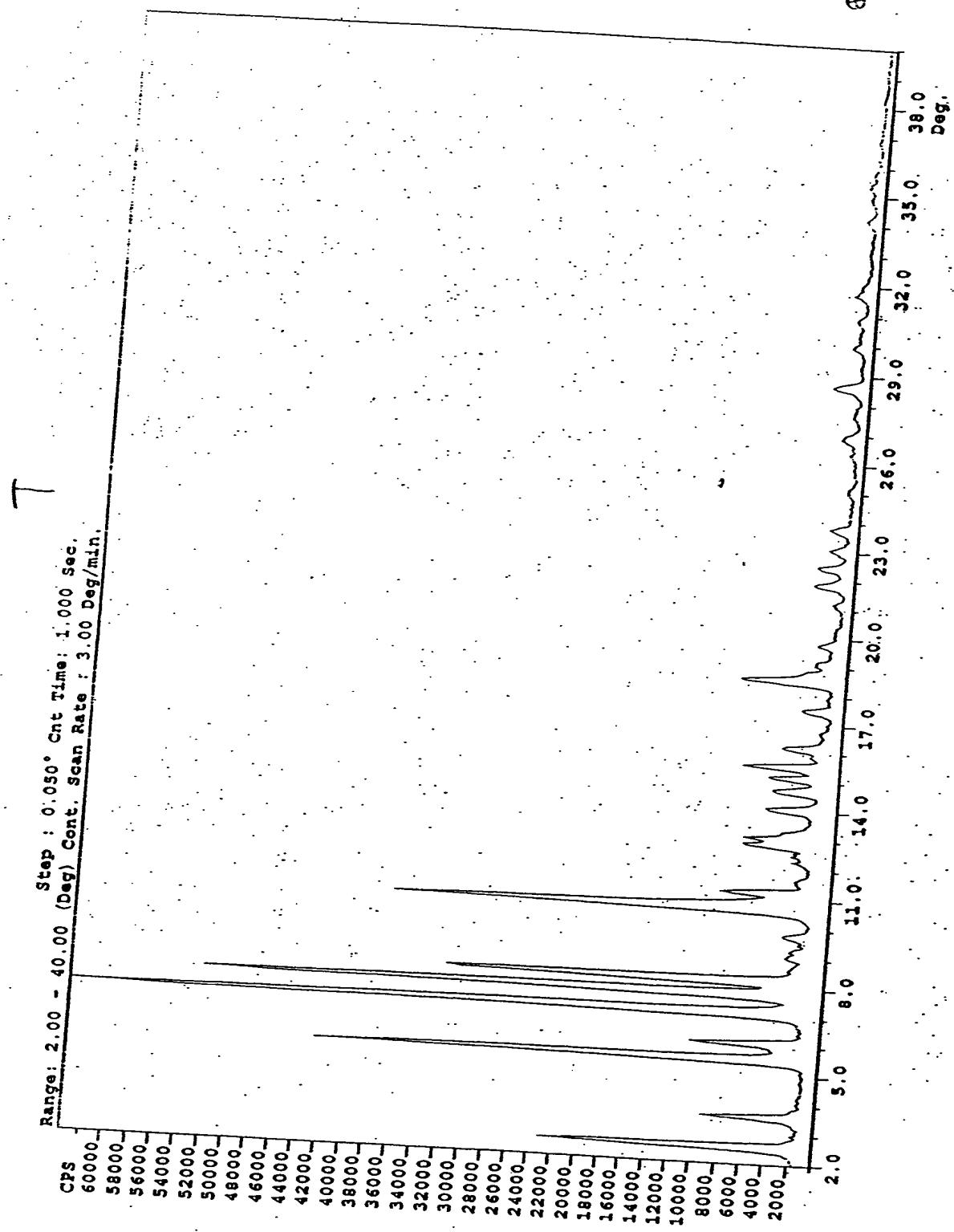


Fig. 17

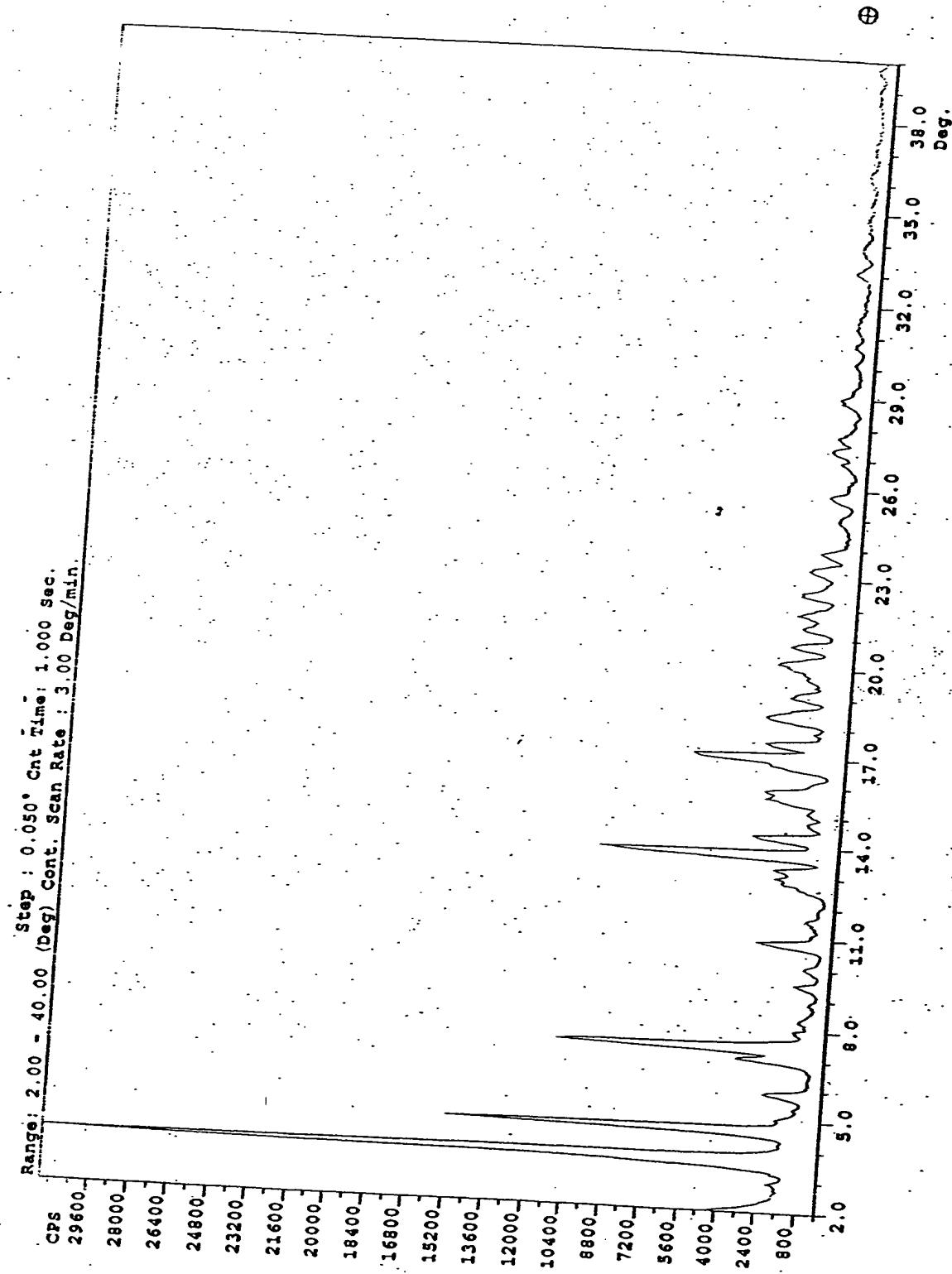


Fig. 18

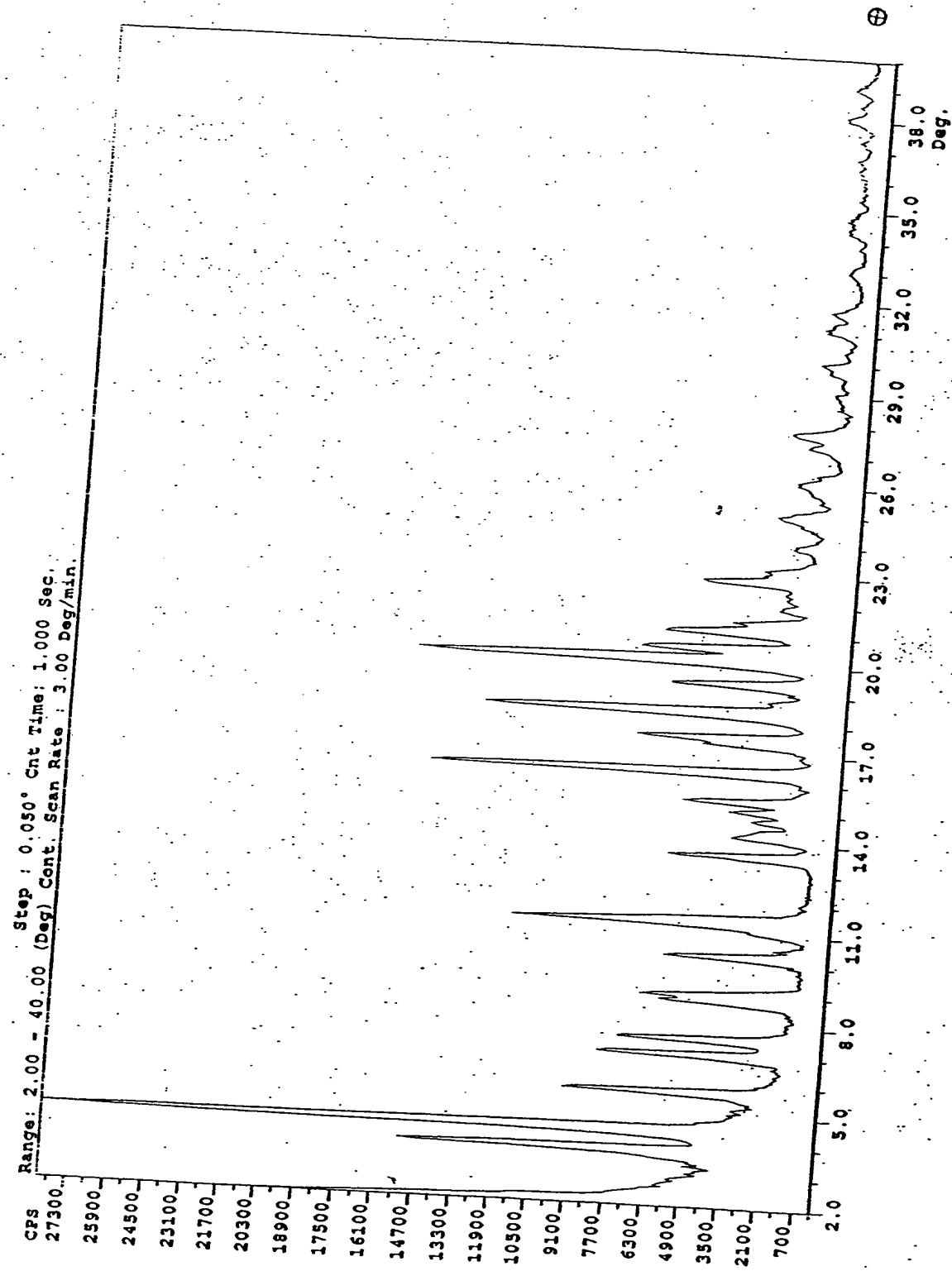


fig 19

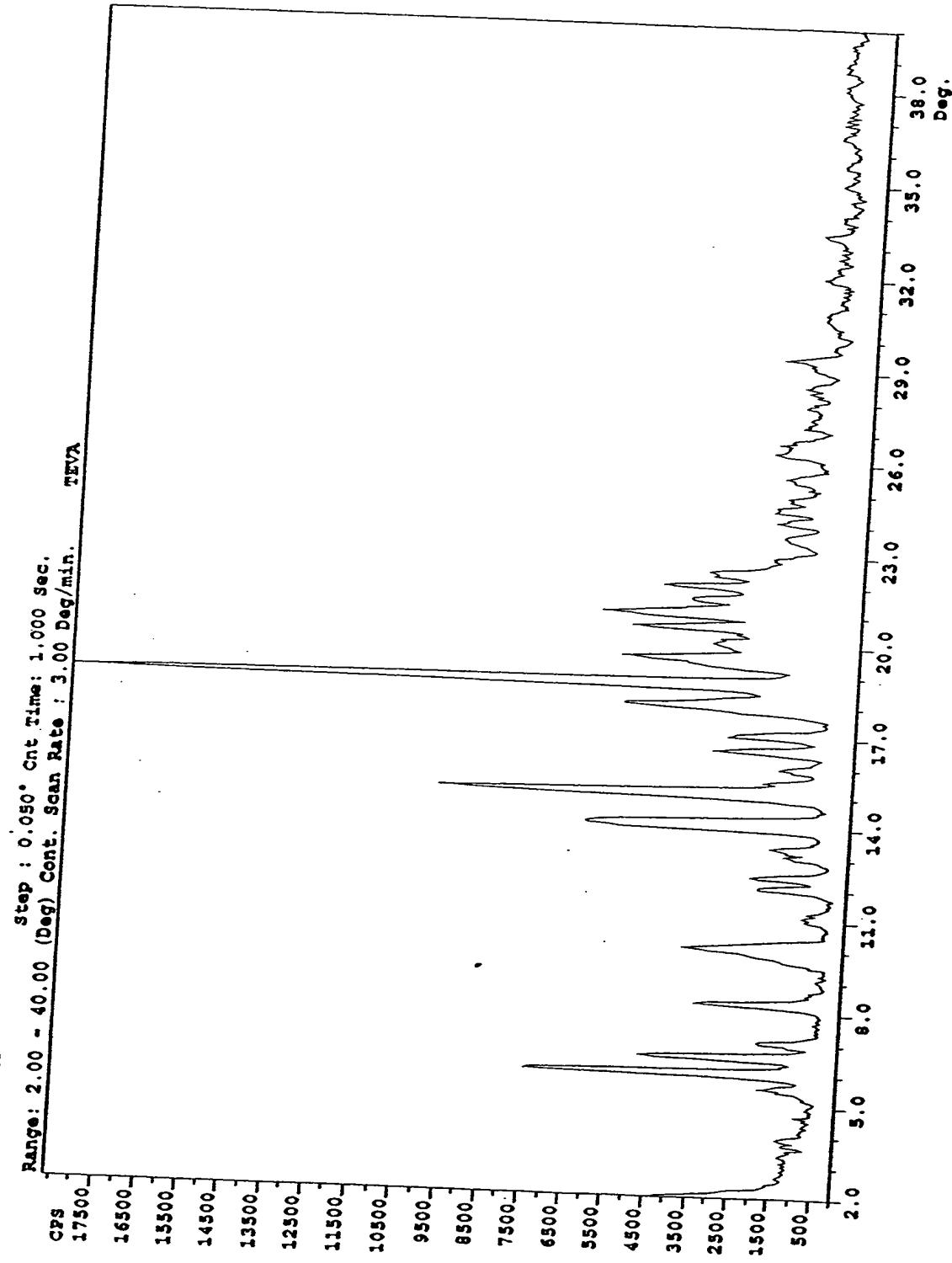


Figure 20 - Natta line Form Z

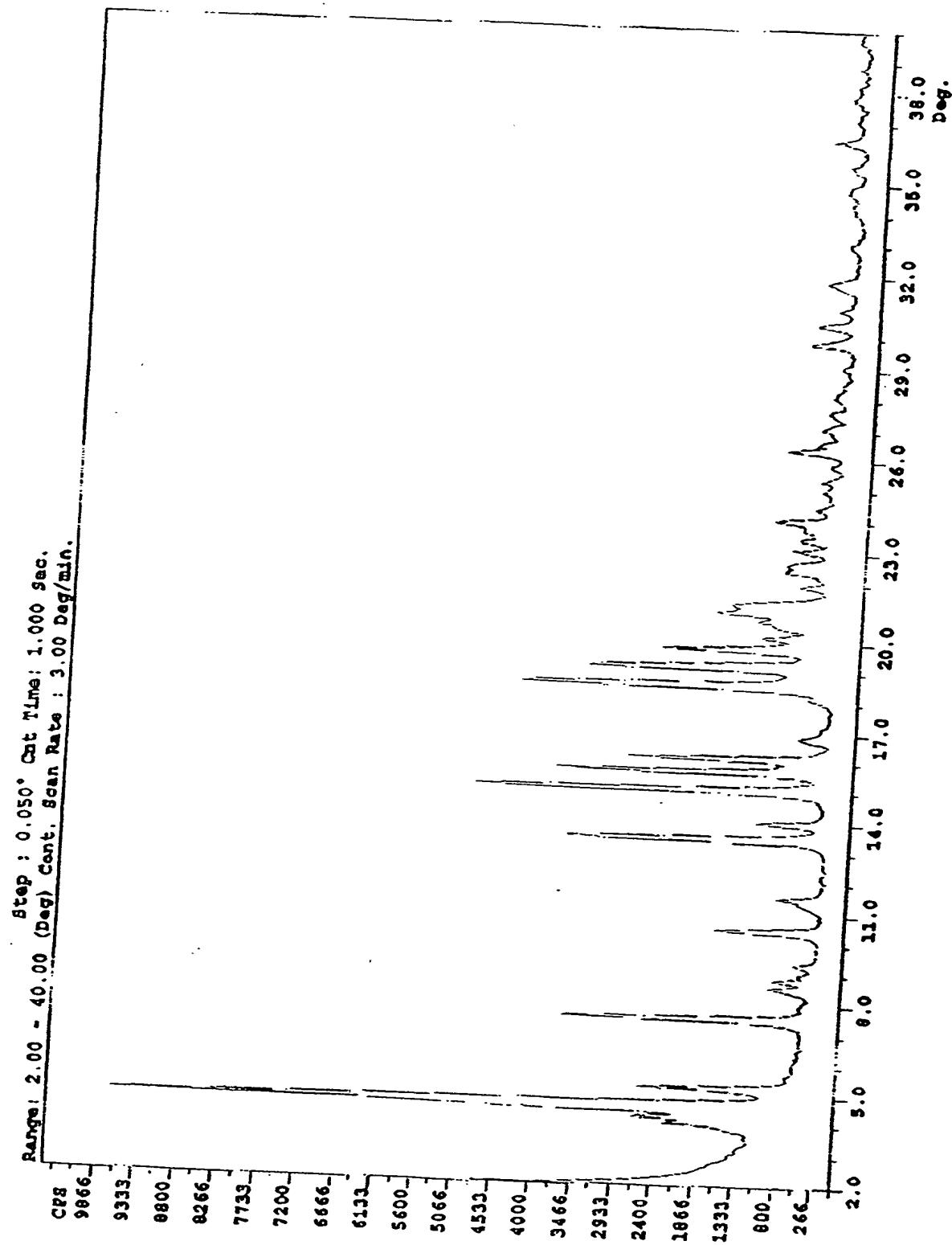


Fig 24  $\alpha$

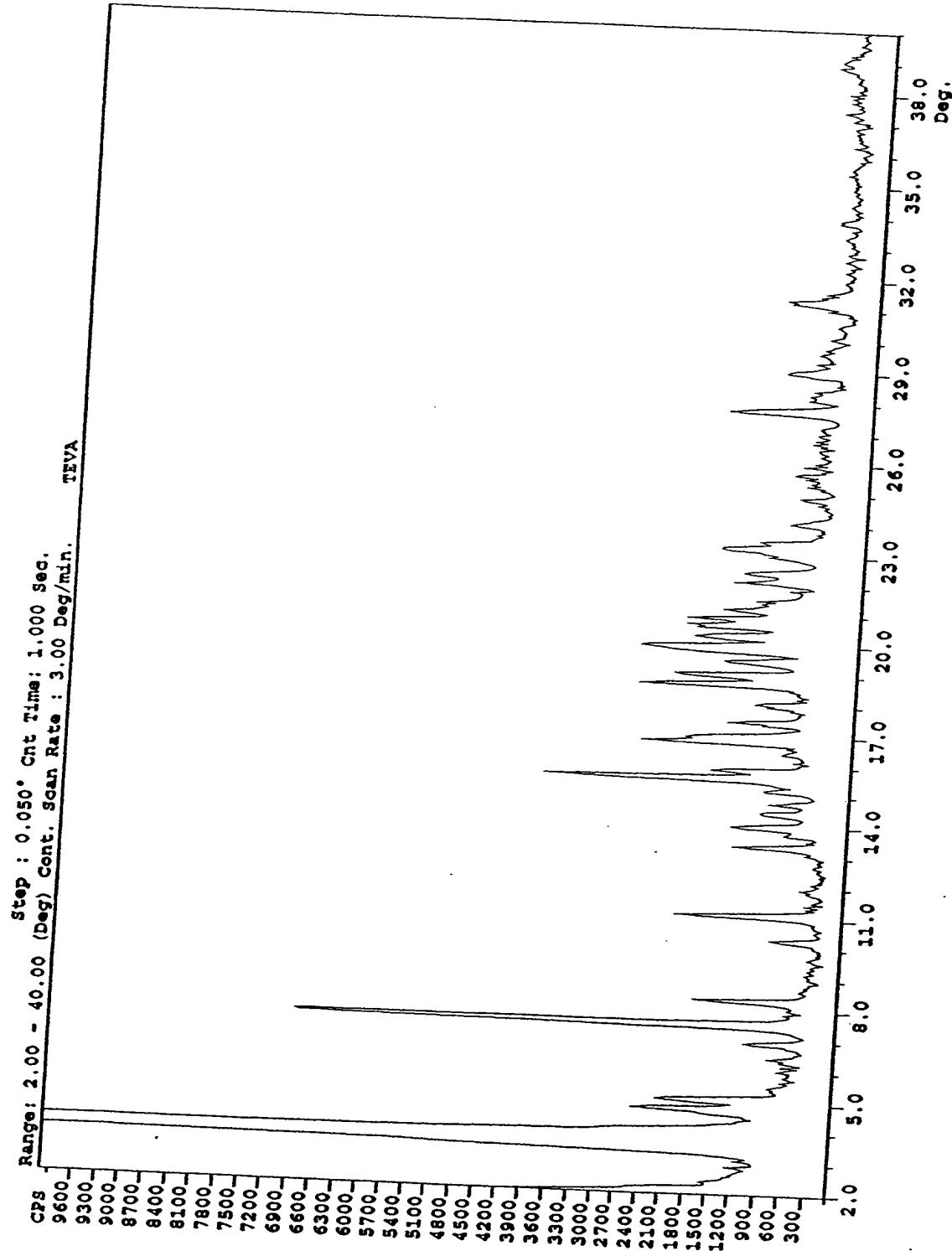


Fig. 28  $\beta$

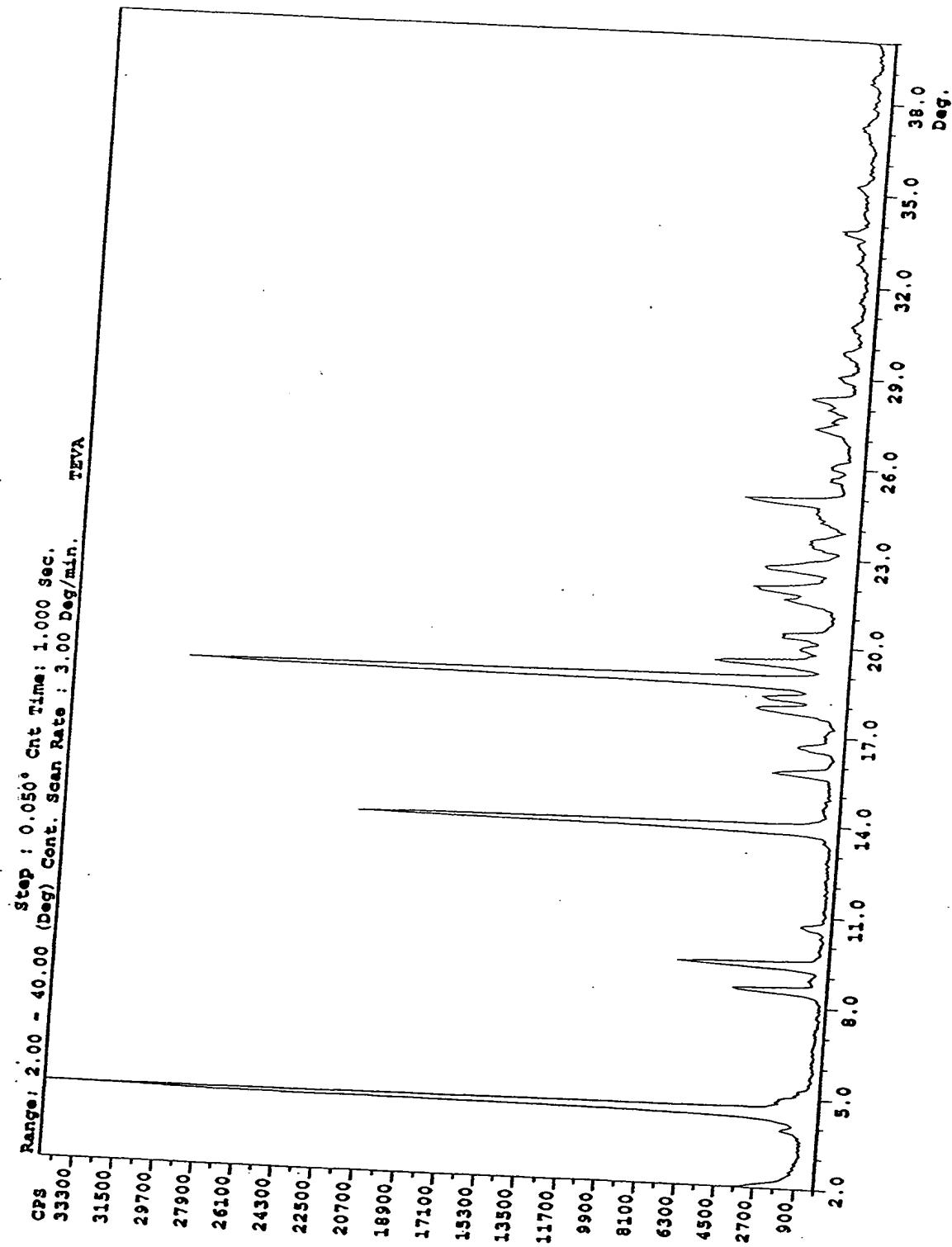


Fig 23 10

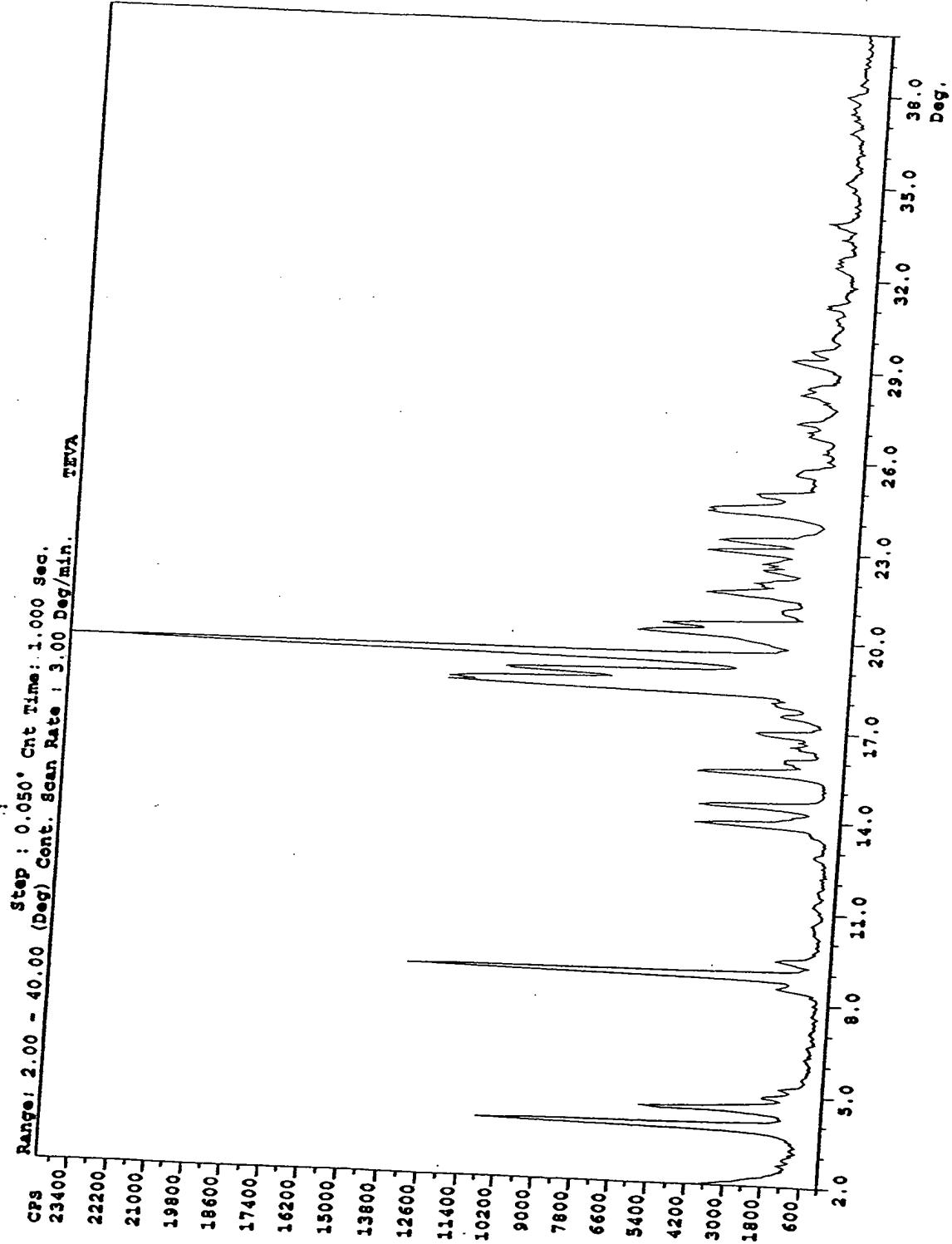


Fig 24

Fig 24

Step : 0.050° Cnt Time: 1.000 sec.  
Range: 2.00 - 40.00 (Deg) Cont. Scan Rate : 3.00 Deg/min.  
CPS 22200  
21000  
19800  
18600  
17400  
16200  
15000  
13800  
12600  
11400  
10200  
9000  
7800  
6600  
5400  
4200  
3000  
1800  
600

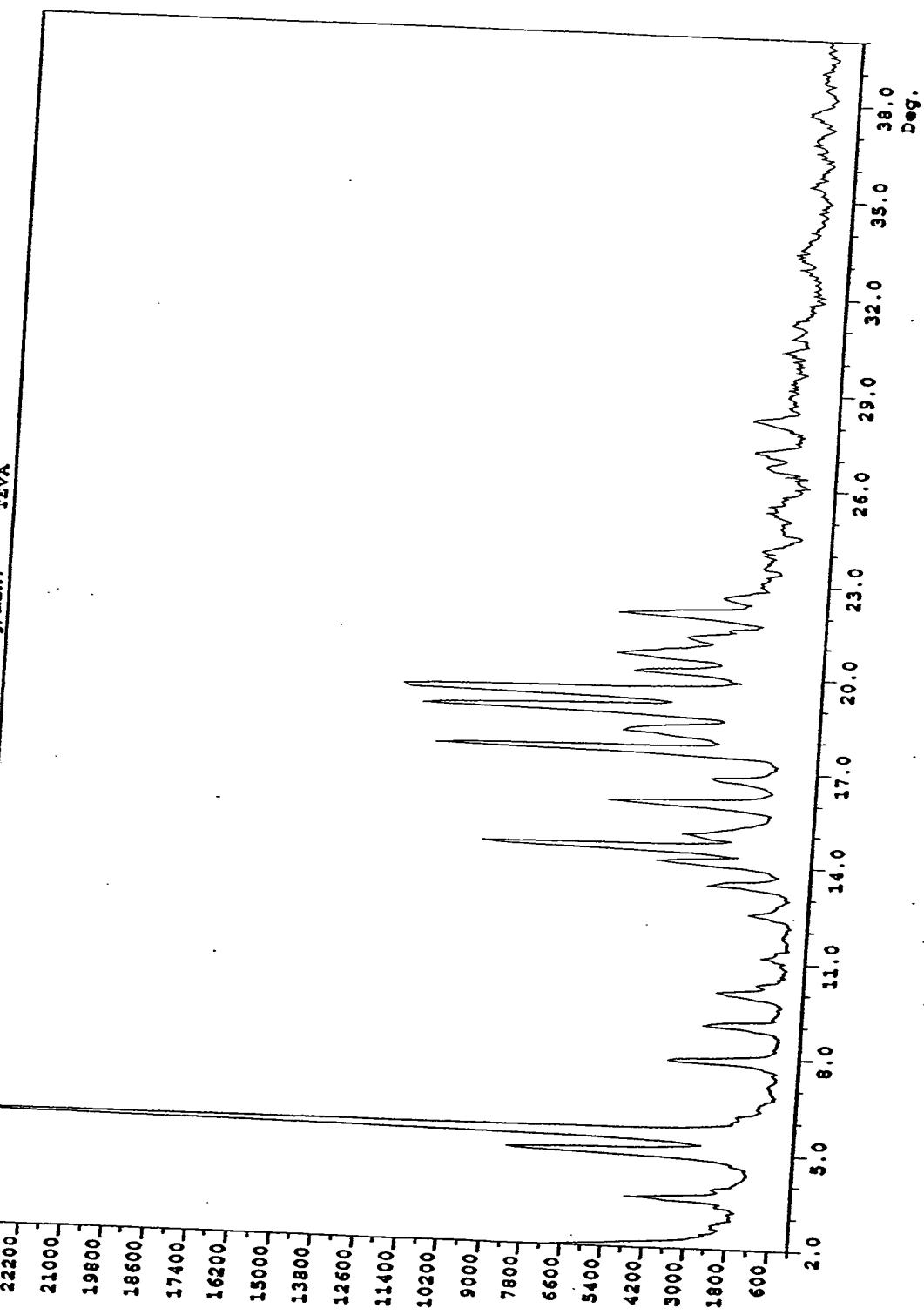


Fig 25

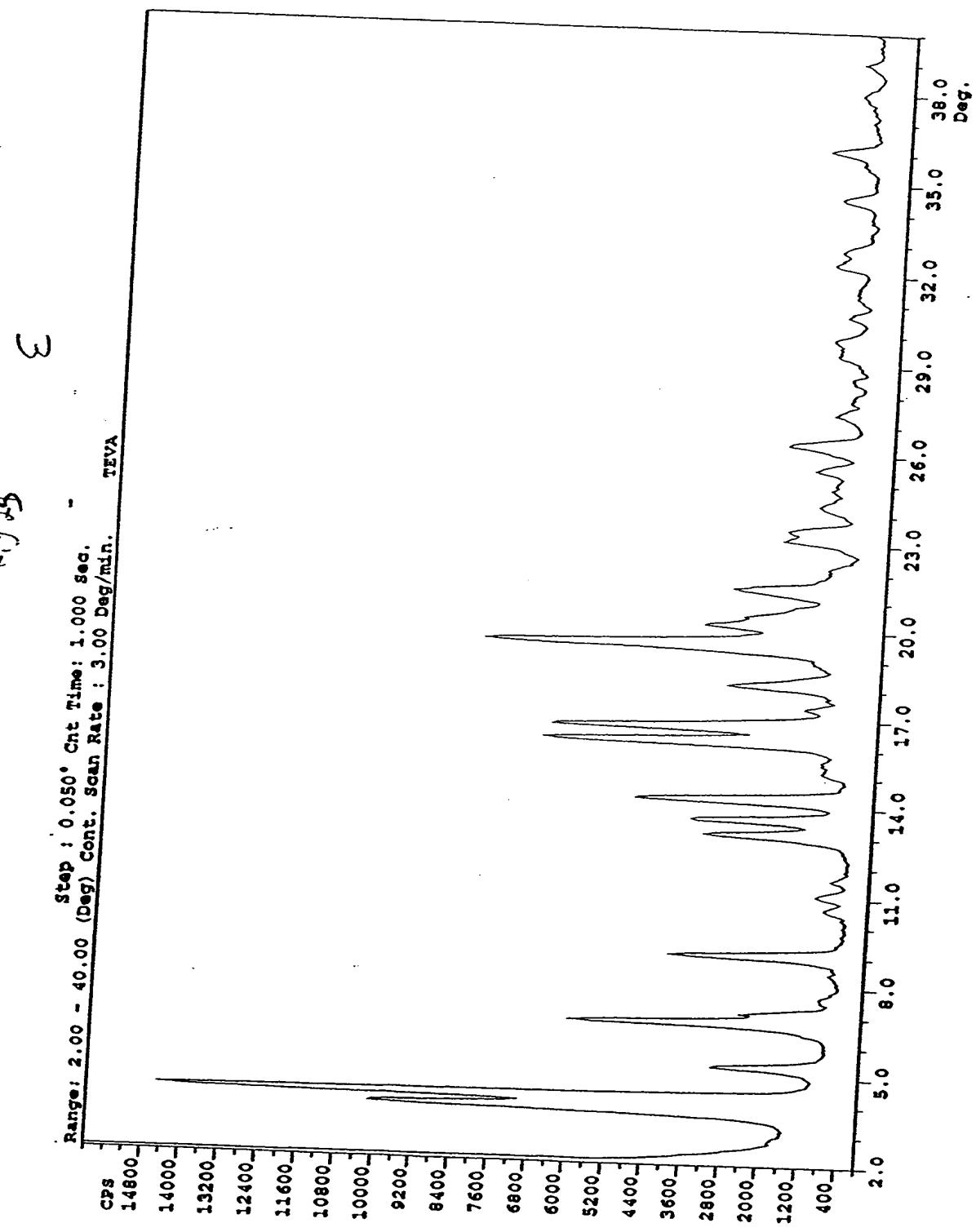


FIGURE 26

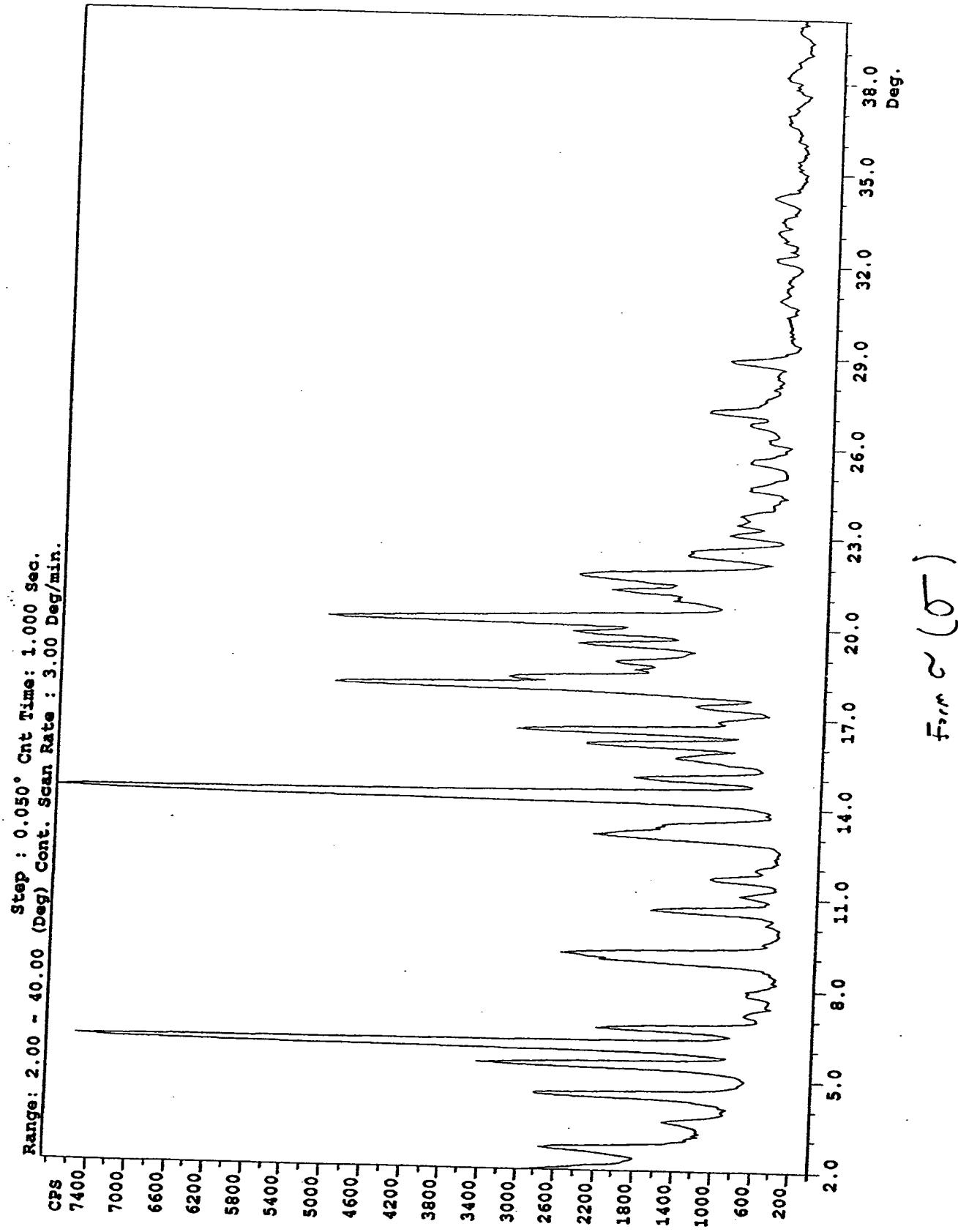


FIGURE 27.

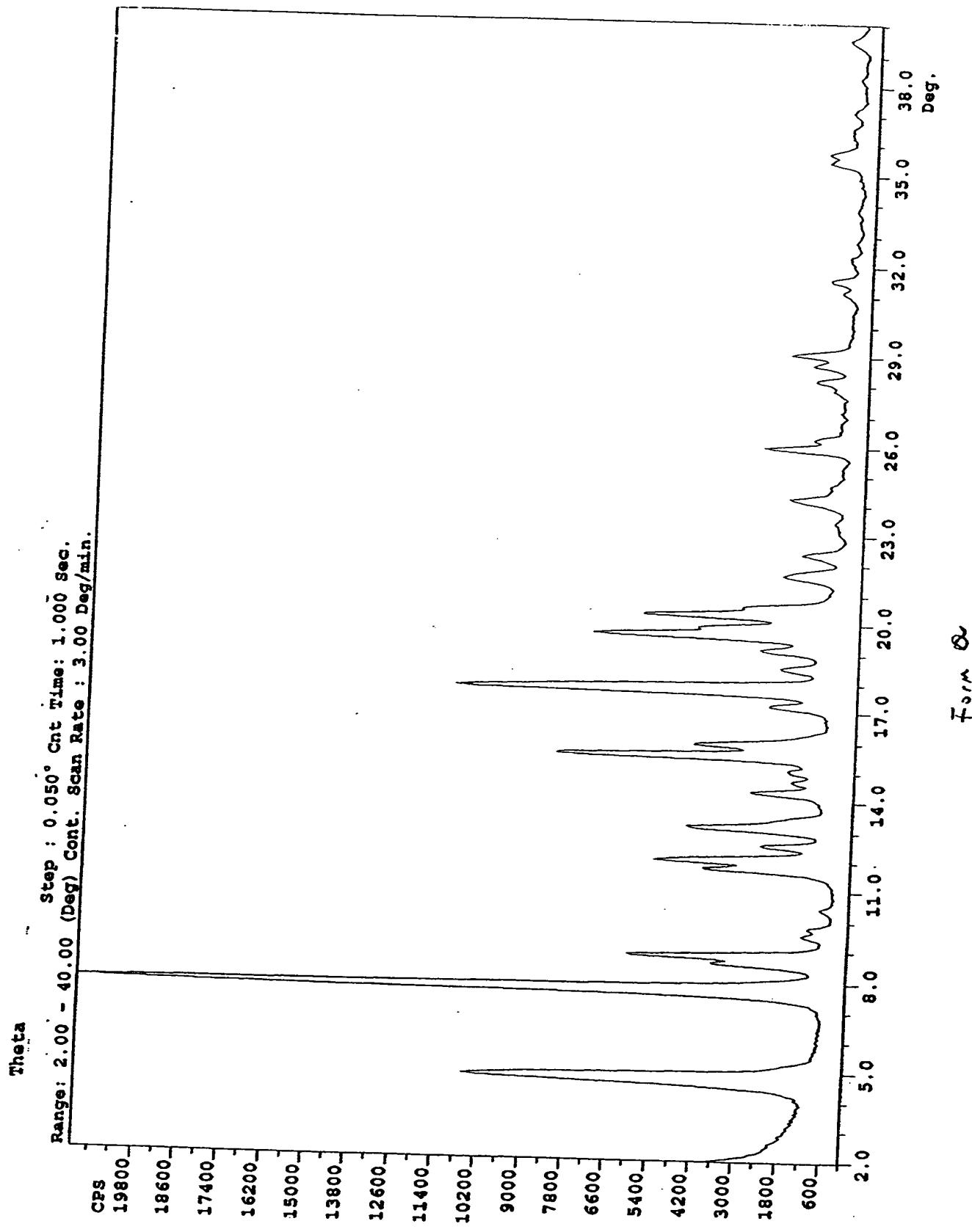


Figure 58 - Thermal stability chart

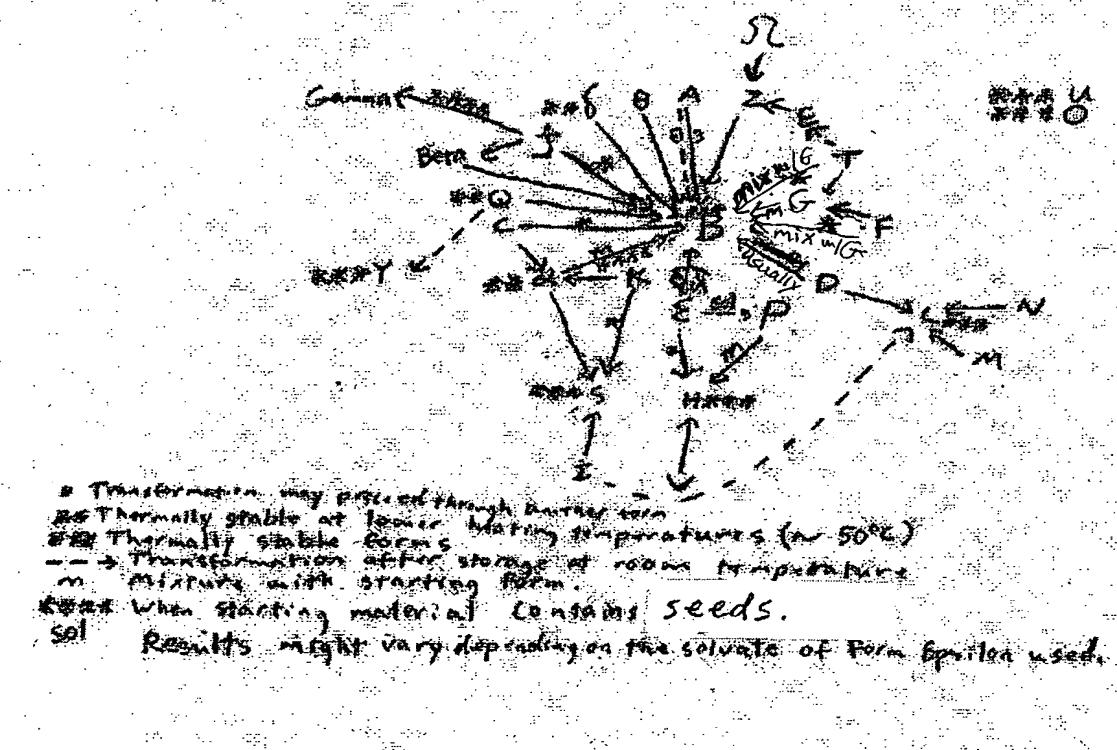


FIGURE 29

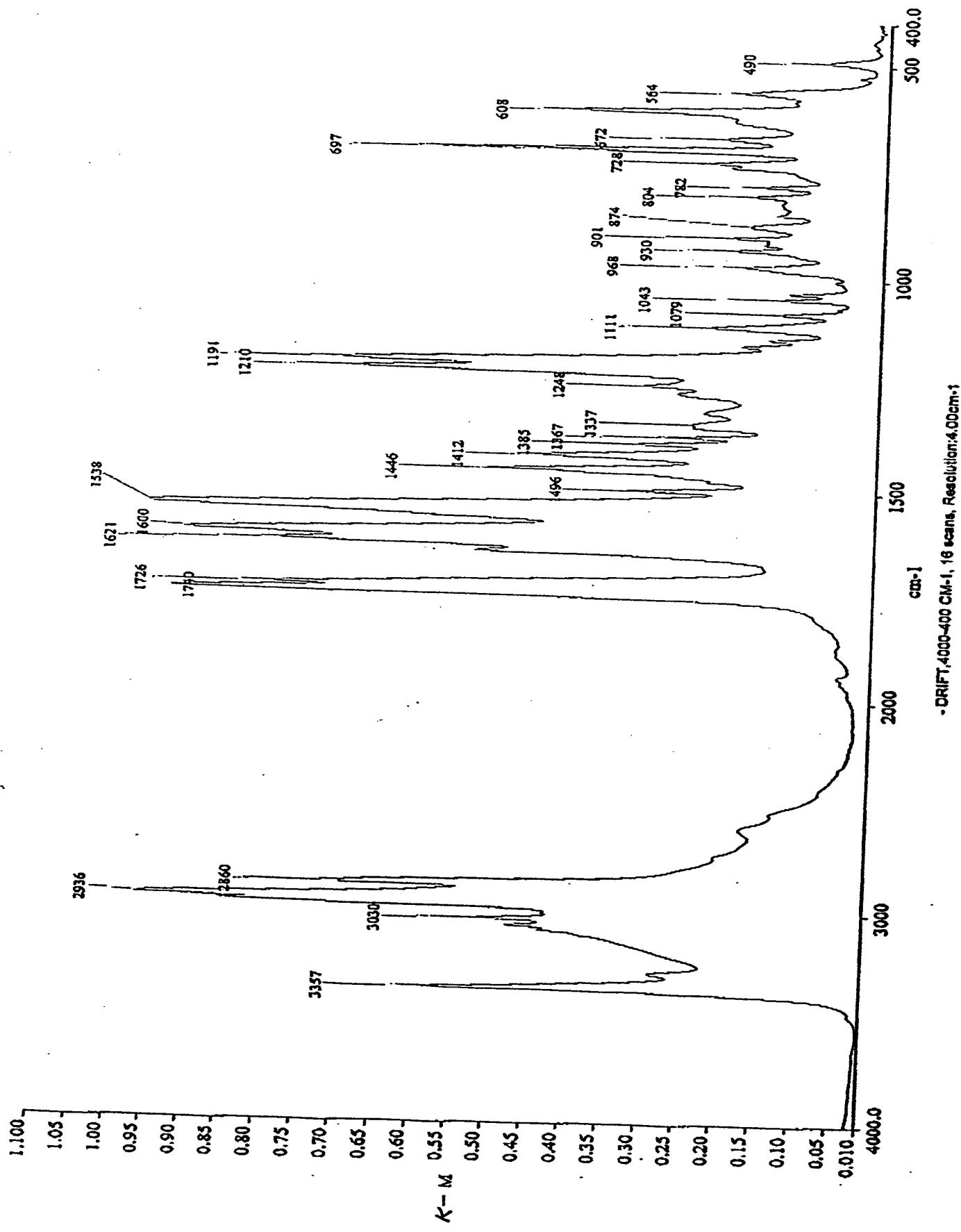


FIGURE 30  
- C-13 NMR

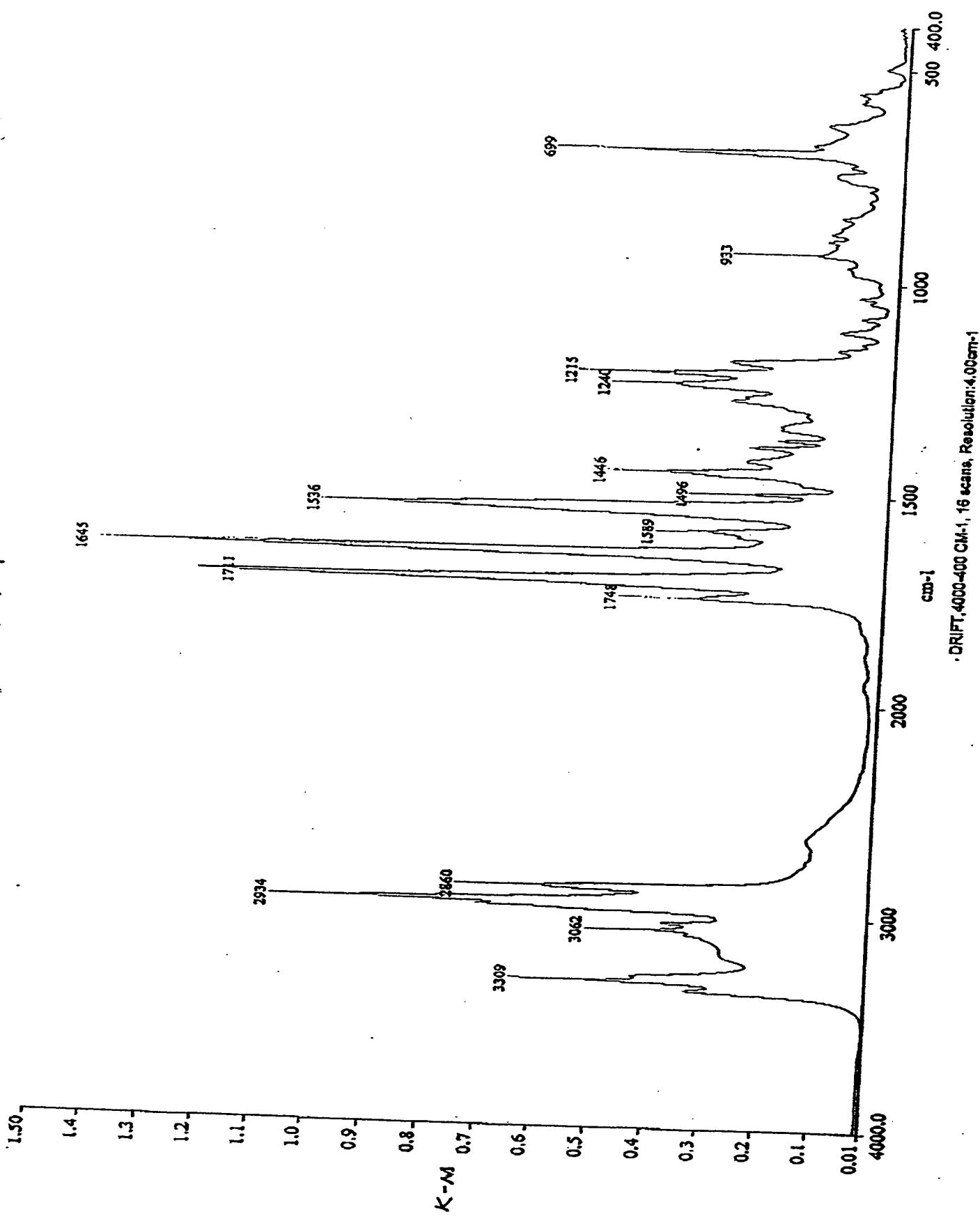


FIGURE 30  
Form Q

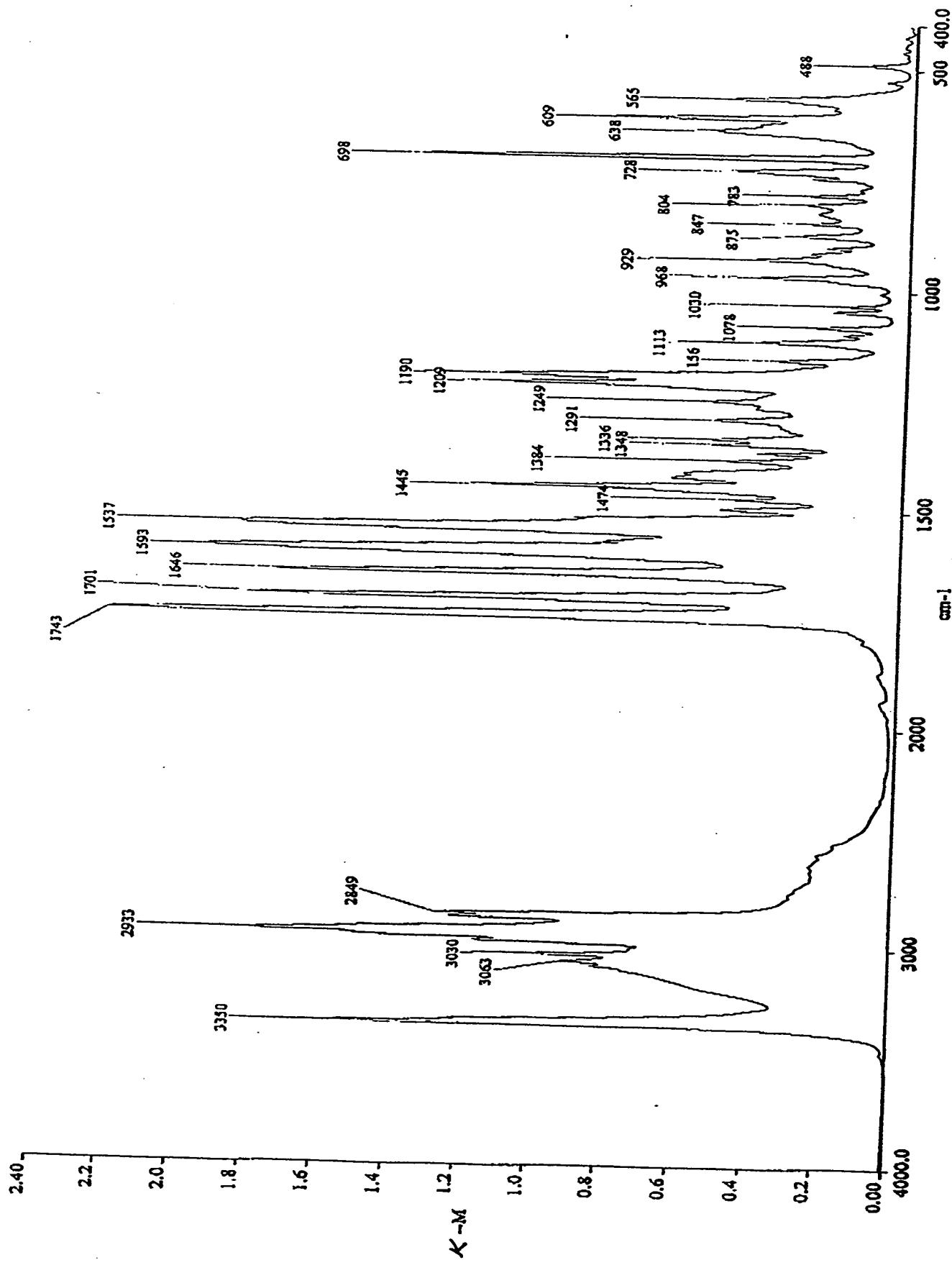


Figure 32 - *Nastaglinide Form Z*

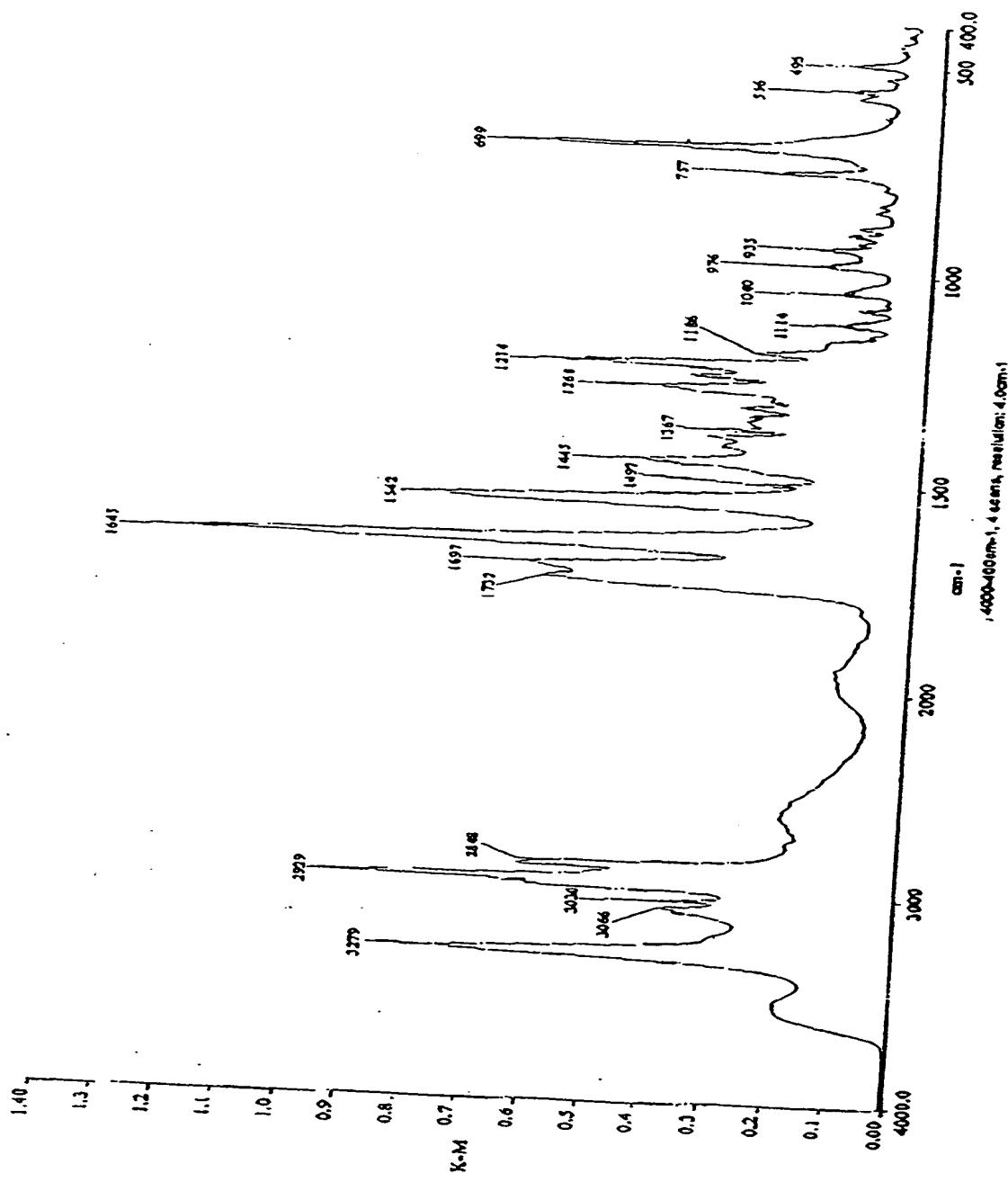


Figure 3  
Firn

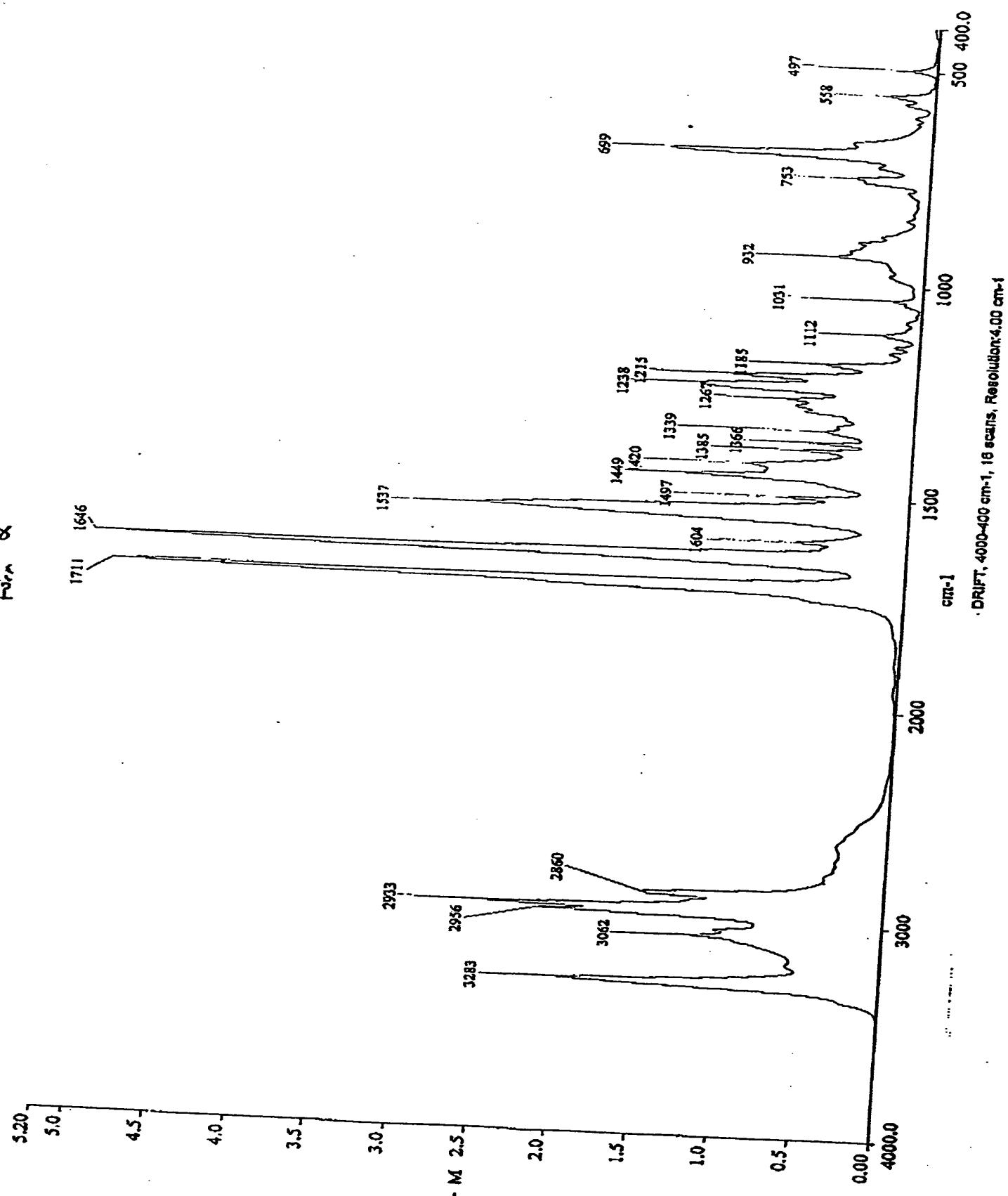
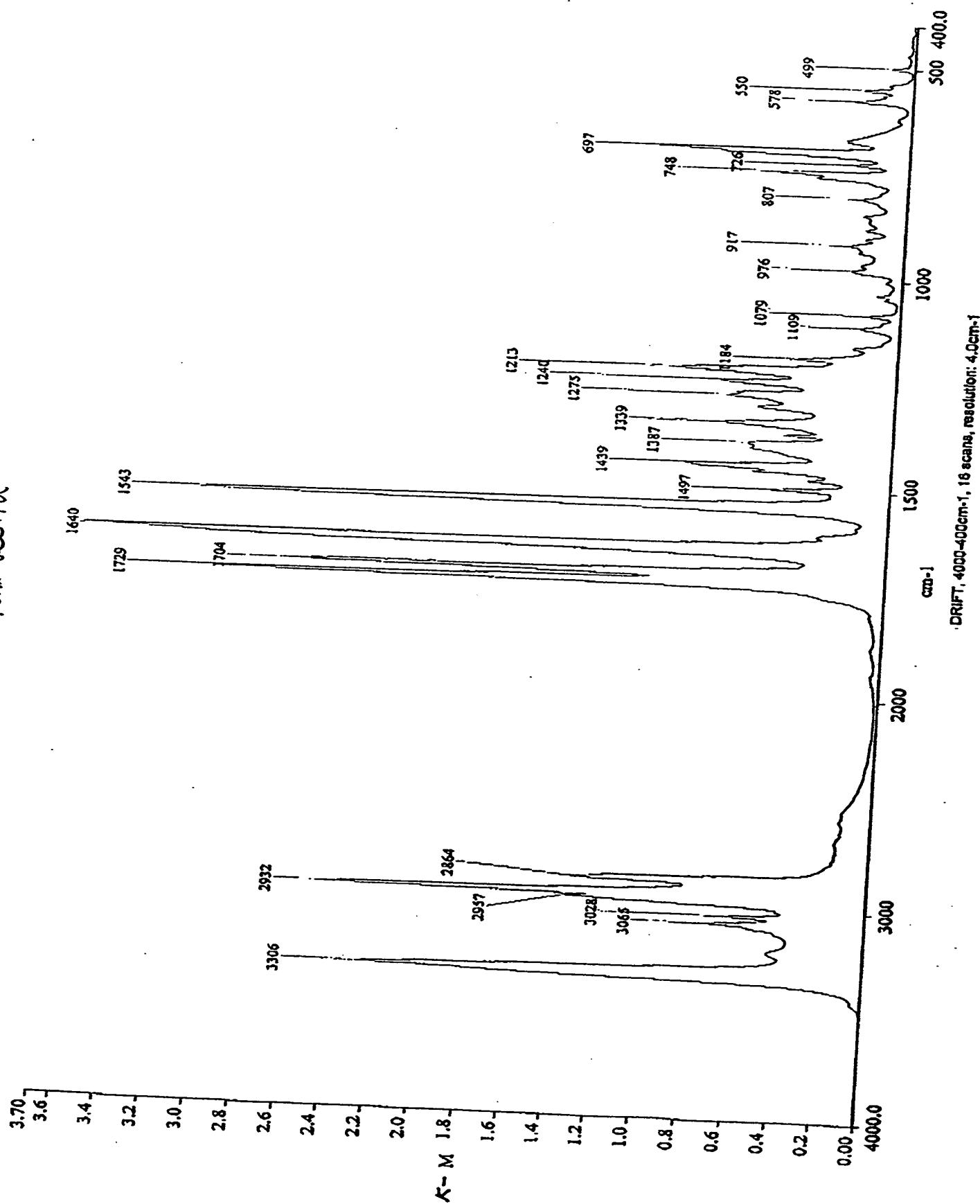


FIGURE 34  
Four  $\Delta t/\alpha$



DRIFT, 4000-400  $\text{cm}^{-1}$ , 16 scans, resolution: 4.0  $\text{cm}^{-1}$

FIGURE 35

- Form  $\delta$

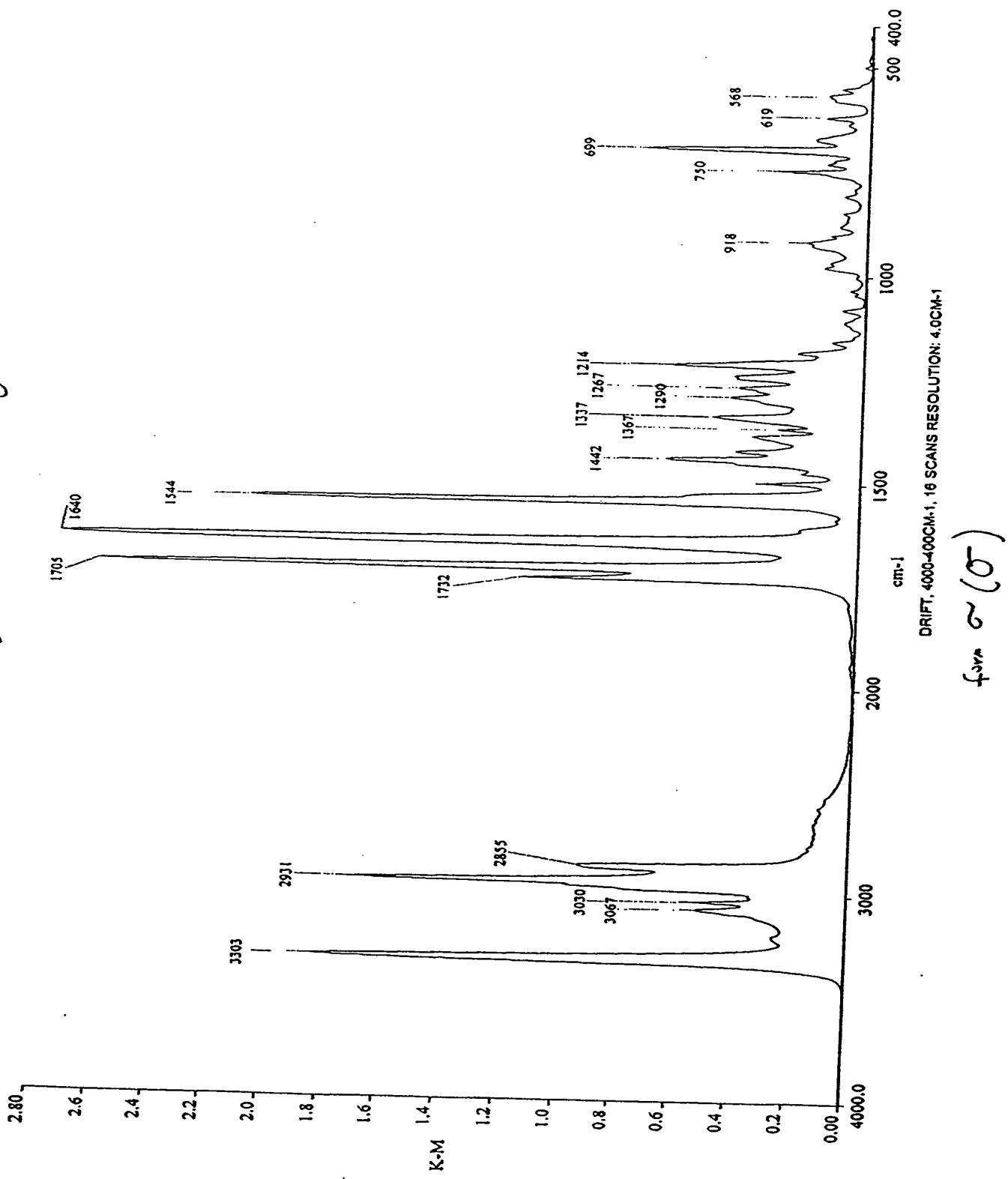


FIGURE 36 Form A

Method: 30-250C, 10C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min N2, 40.0 ml/min

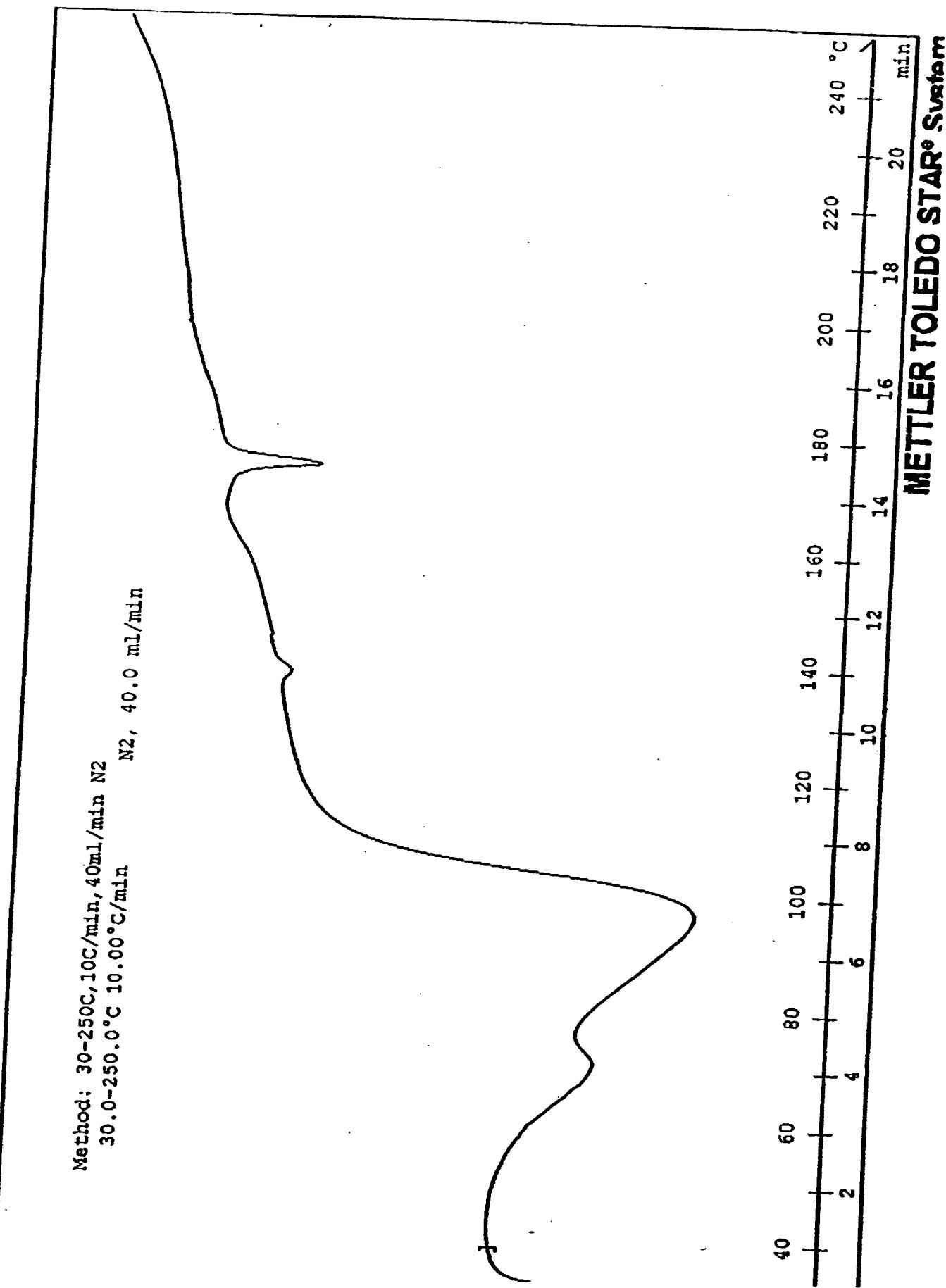


FIGURE 39

Form D

Method: 30-250C, 10C/min, 40mL/min N2  
30.0-250.0°C 10.00°C/min  
N2, 40.0 mL/min

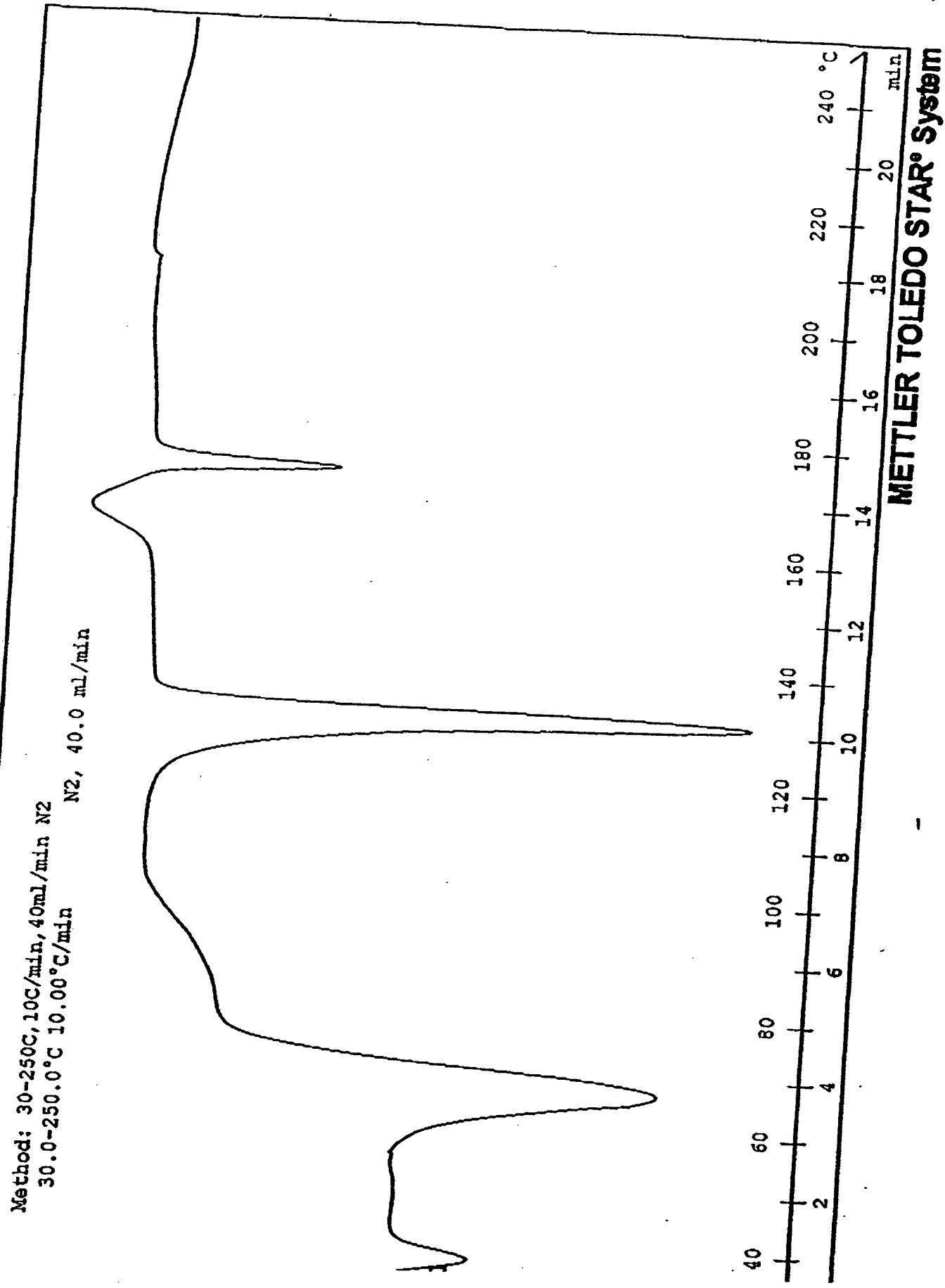
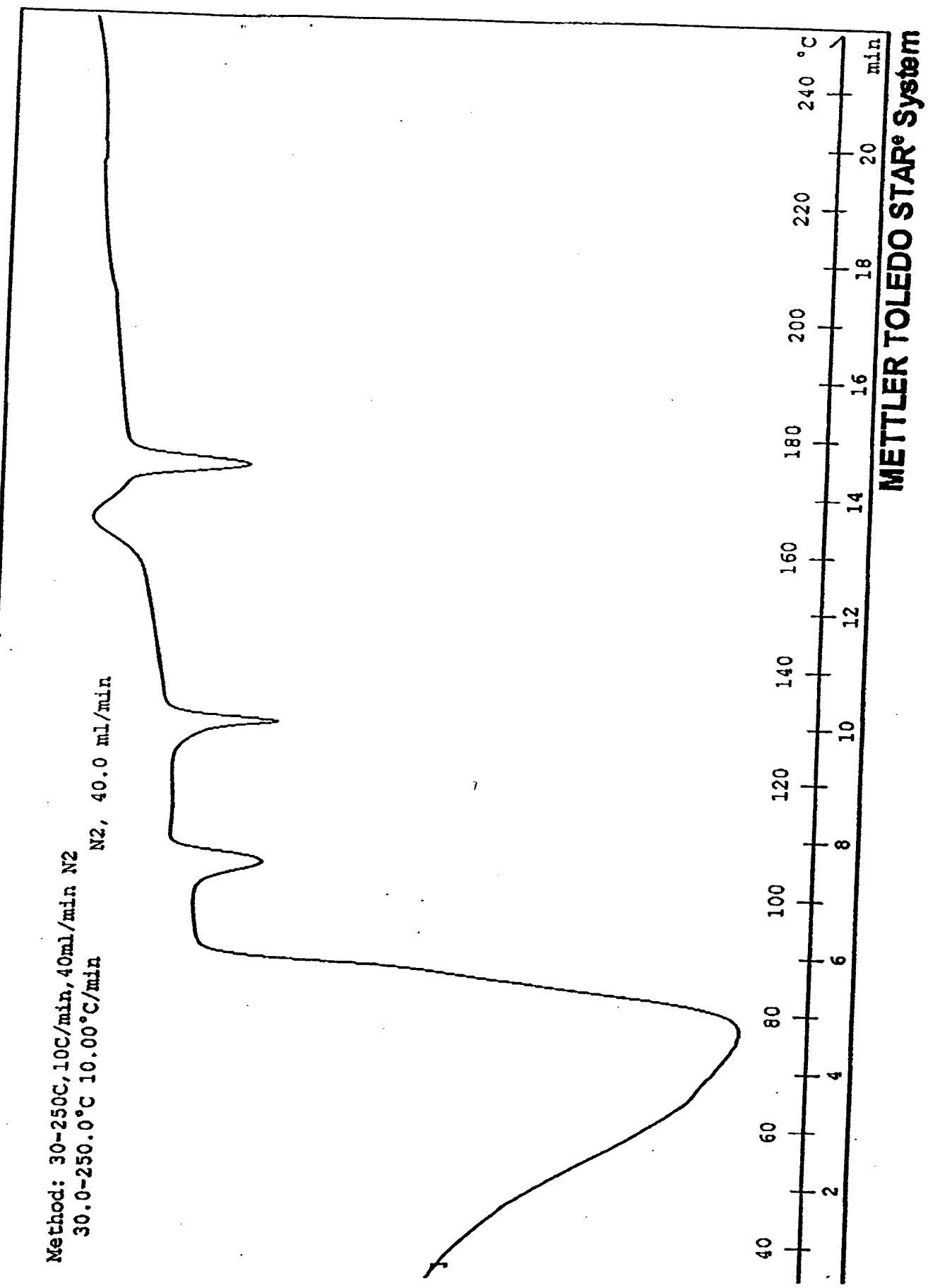


FIGURE 36

Form E

Method: 30-250C, 10C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min N2, 40.0 ml/min



39  
FIGURE 4

Method: 30-250C, 10C/min, 40ml/min N2  
30.0-250.0 °C 10.00 °C/min  
N2, 40.0 ml/min

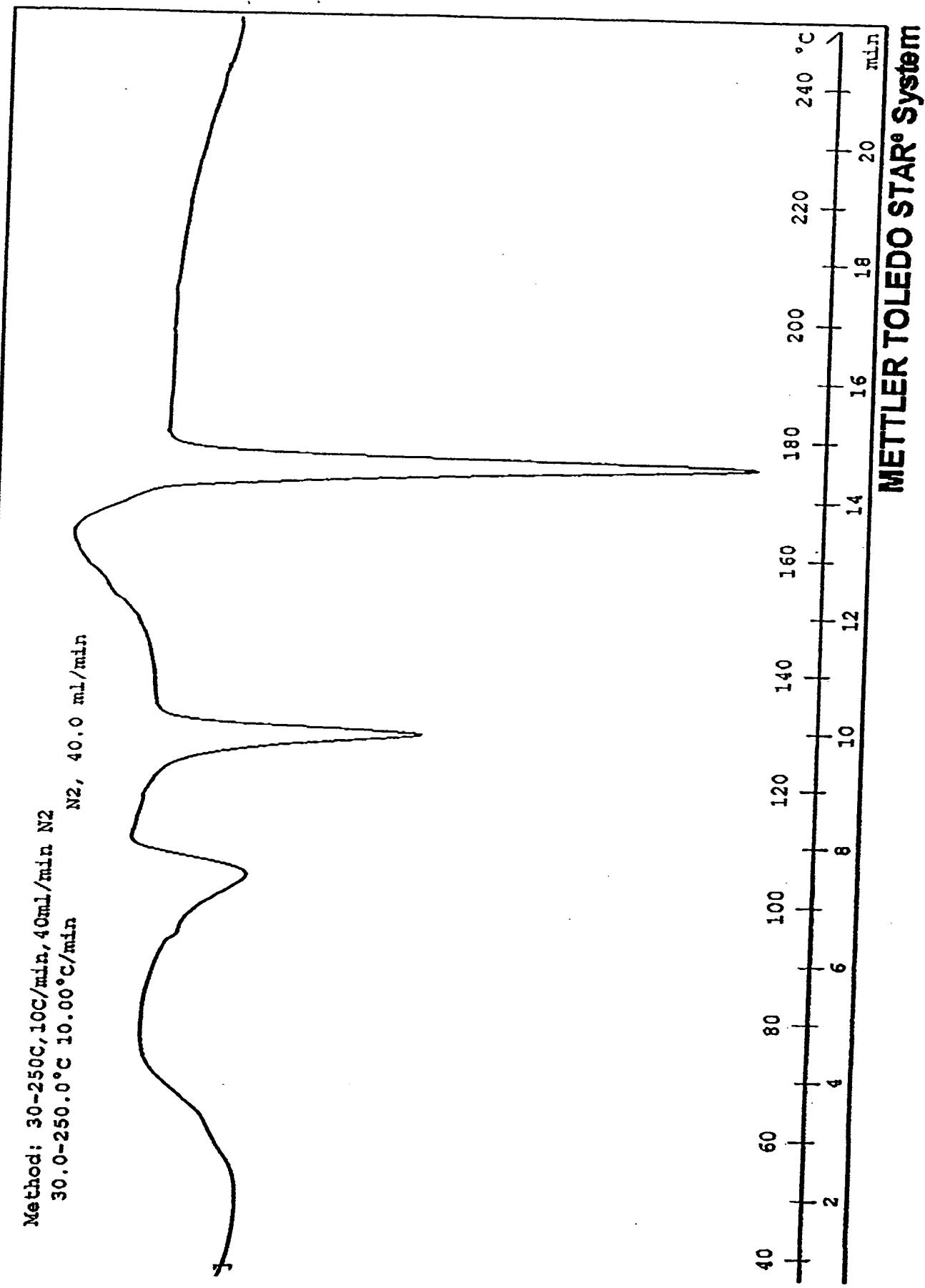


FIGURE 28

XO

Method: 30-250C, 10C/min, 40mL/min N2  
30.0-250.0°C 10.00°C/min N2, 40.0 mL/min

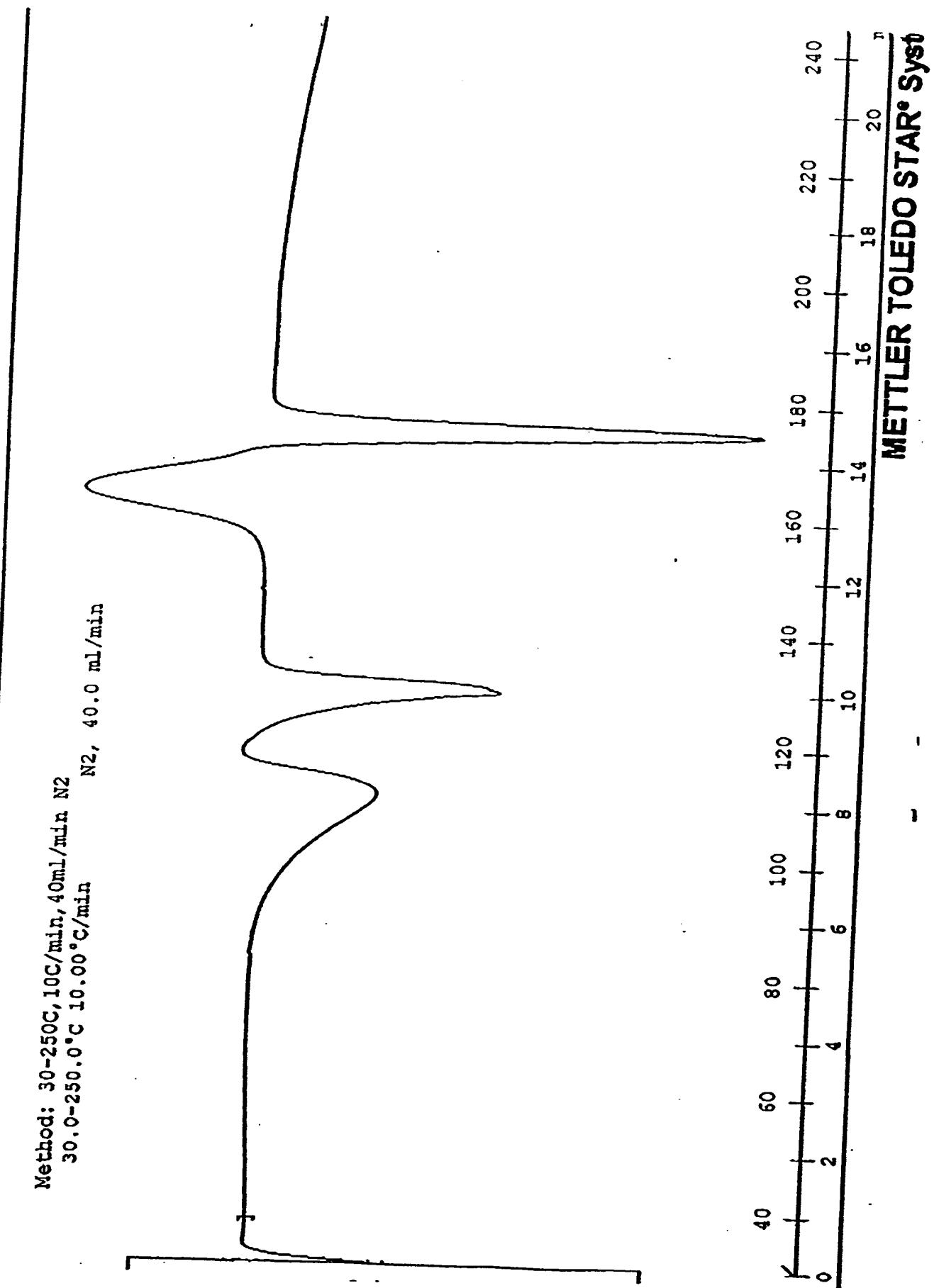


FIGURE 2941

Form I

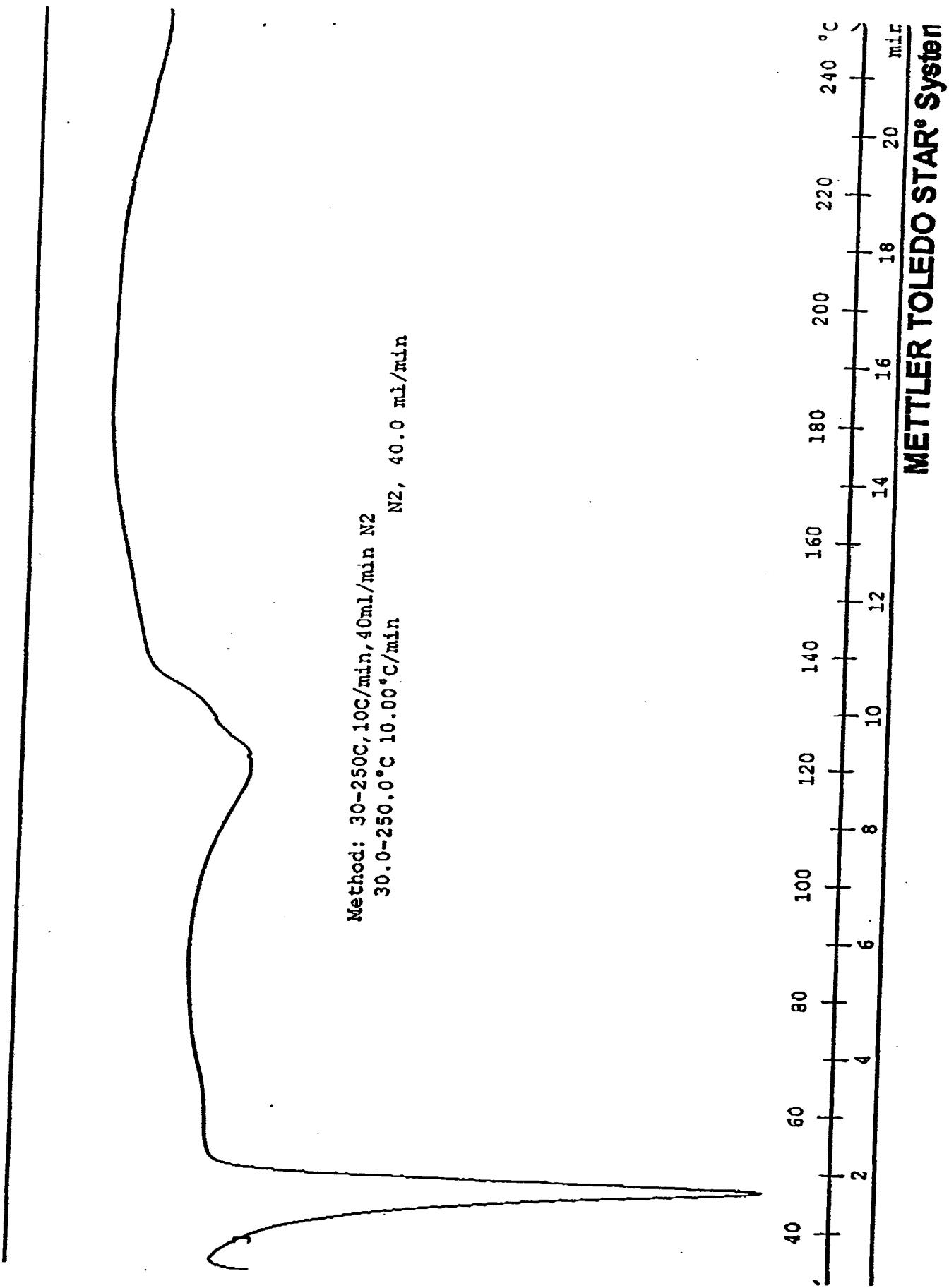


FIGURE 42  
Form J

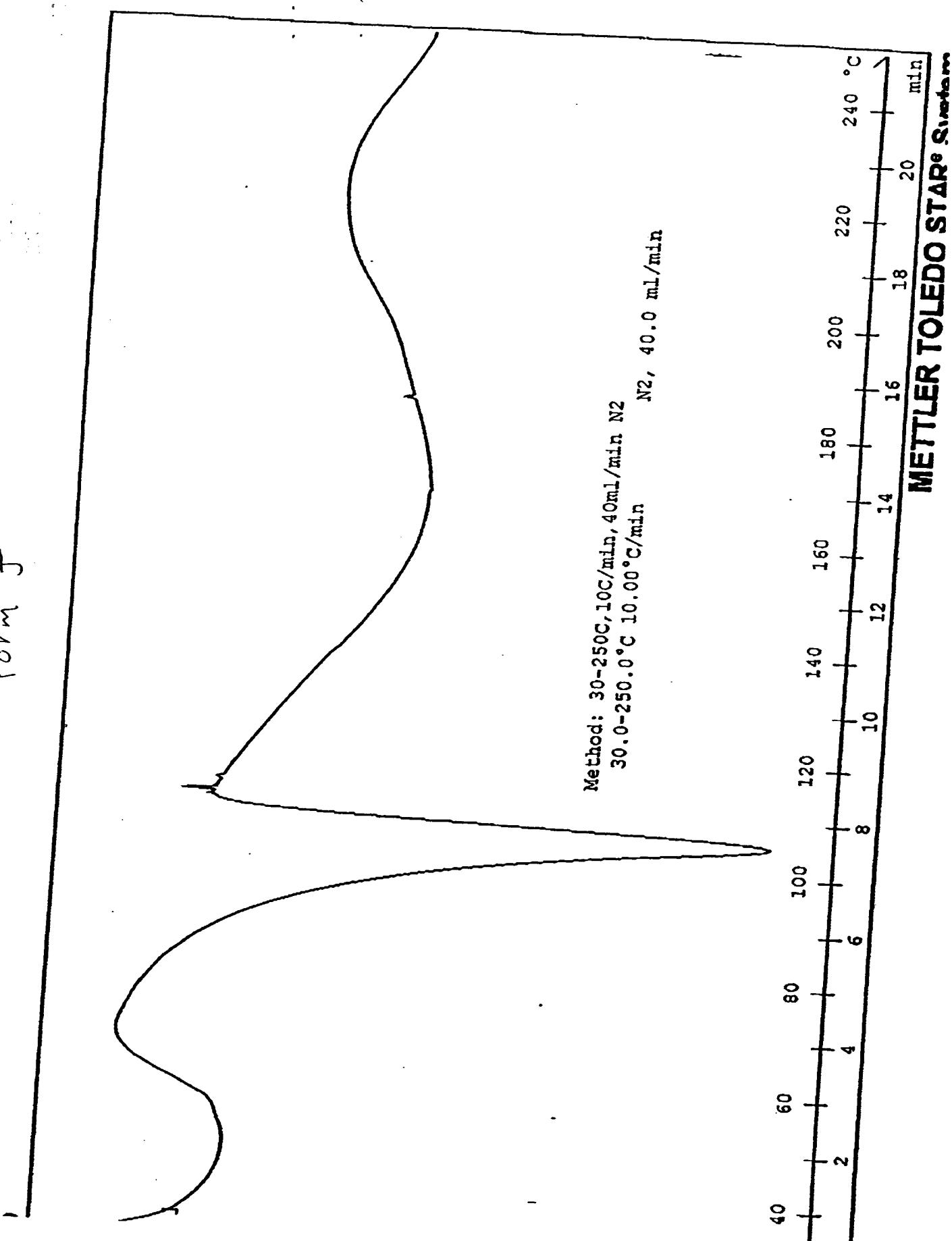


FIGURE 4/3  
Form K

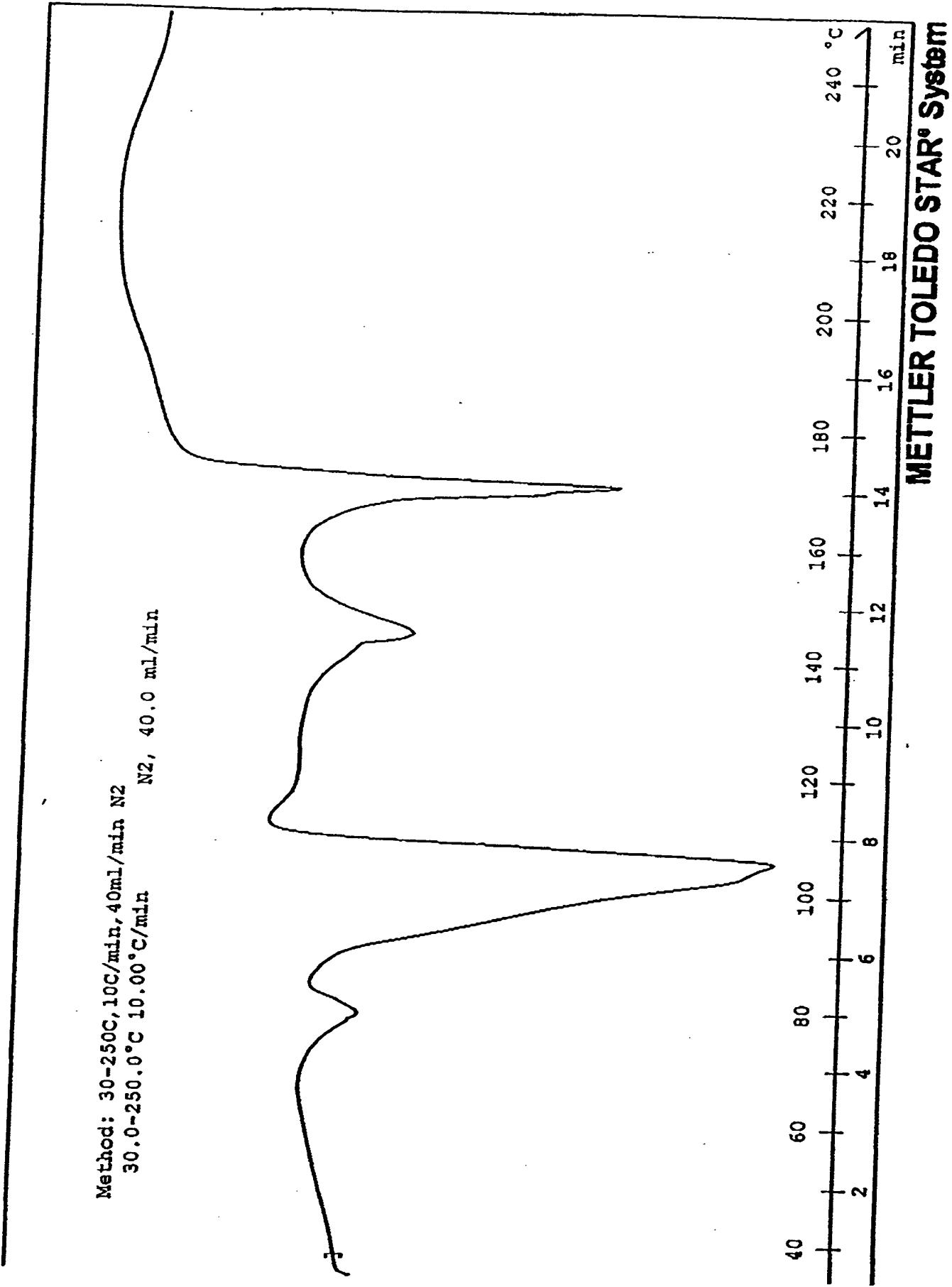


FIGURE 42 414  
Form L

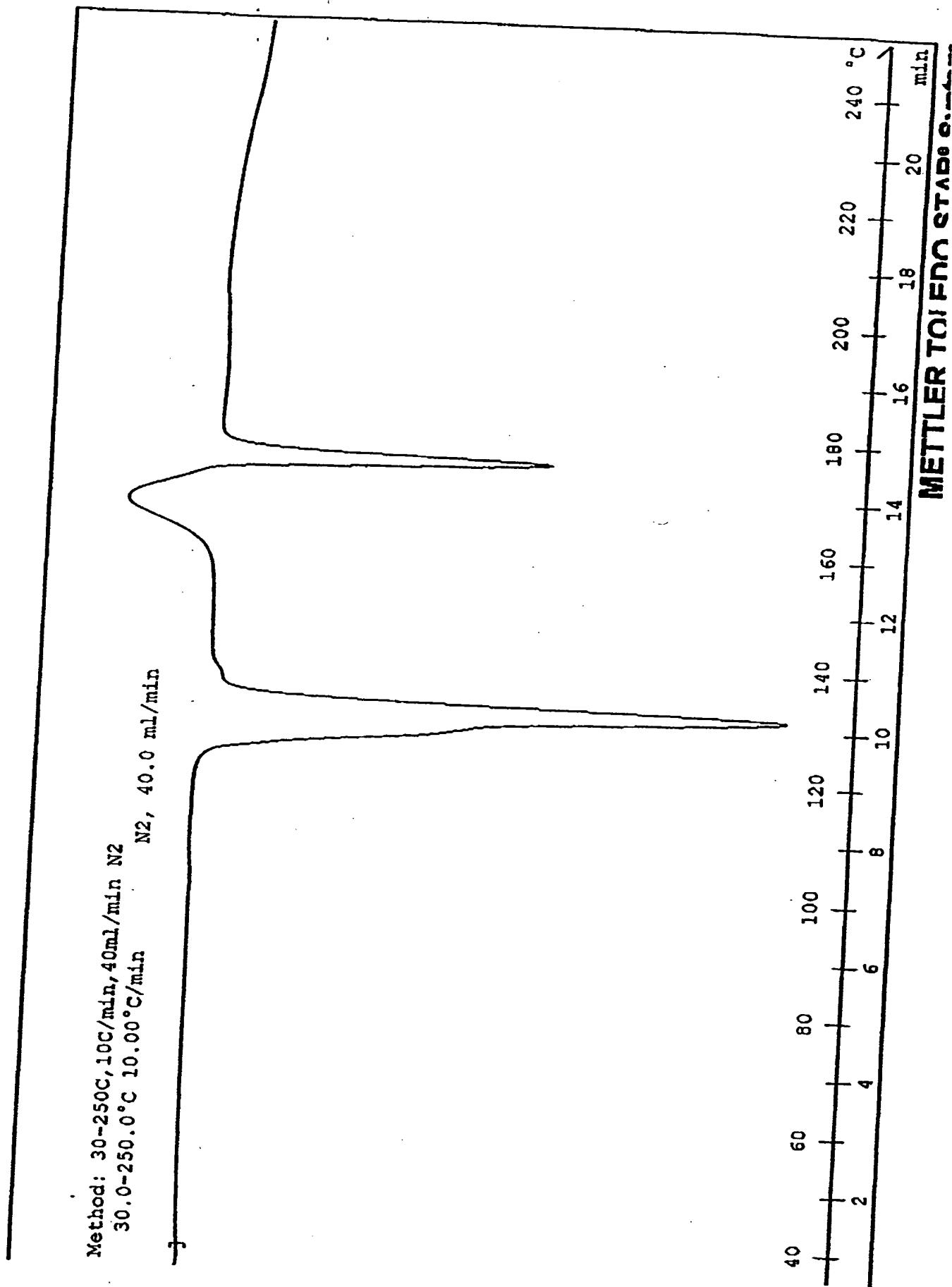


Figure no 45  
Form M

Method: 30-250C, 10C/min, 40mL/min N2  
30.0-250.0 °C 10.00 °C/min N2, 40.0 mL/min

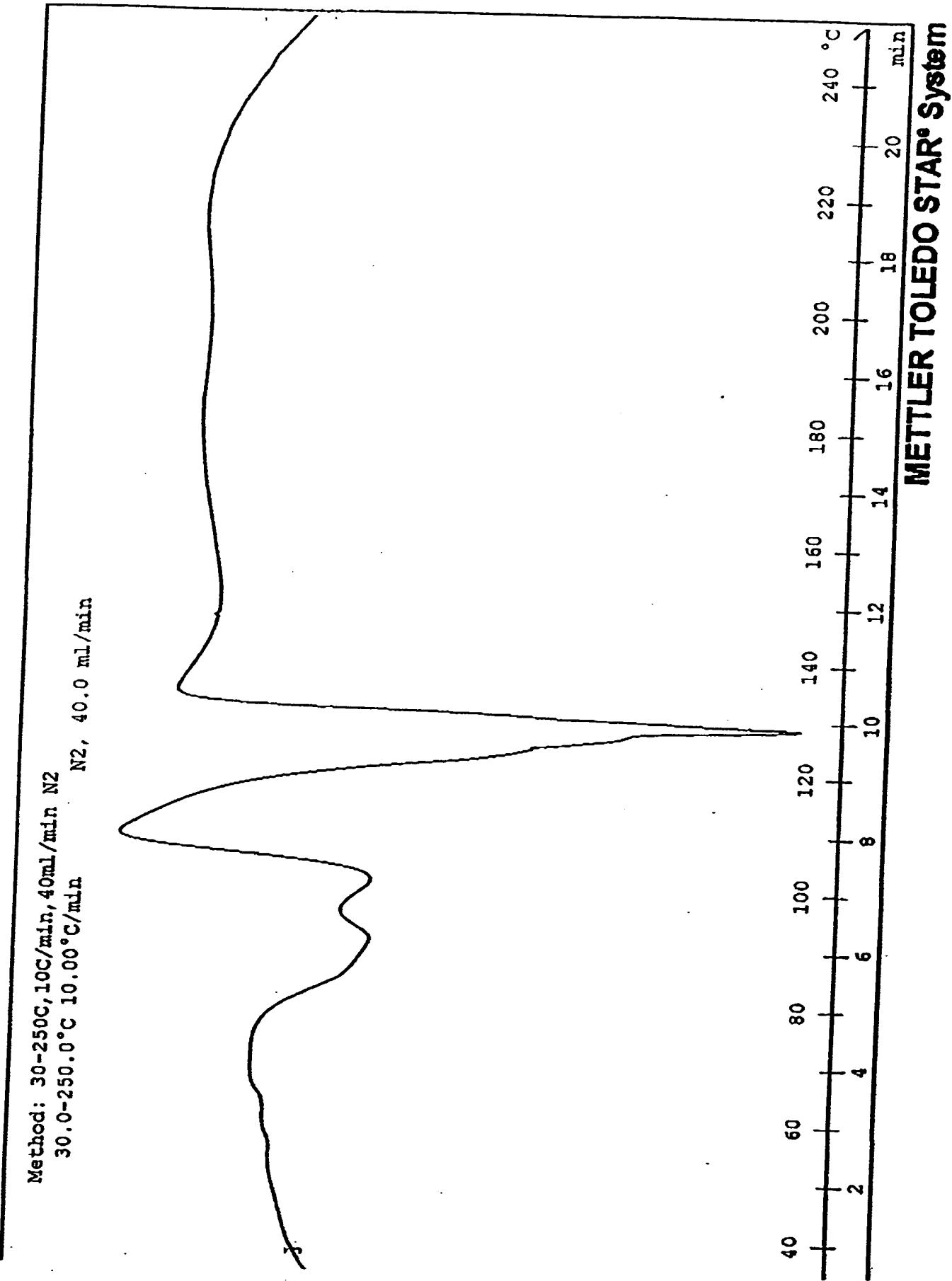


FIGURE 46  
Form N

Method: 30-250C, 10C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min N2, 40.0 ml/min

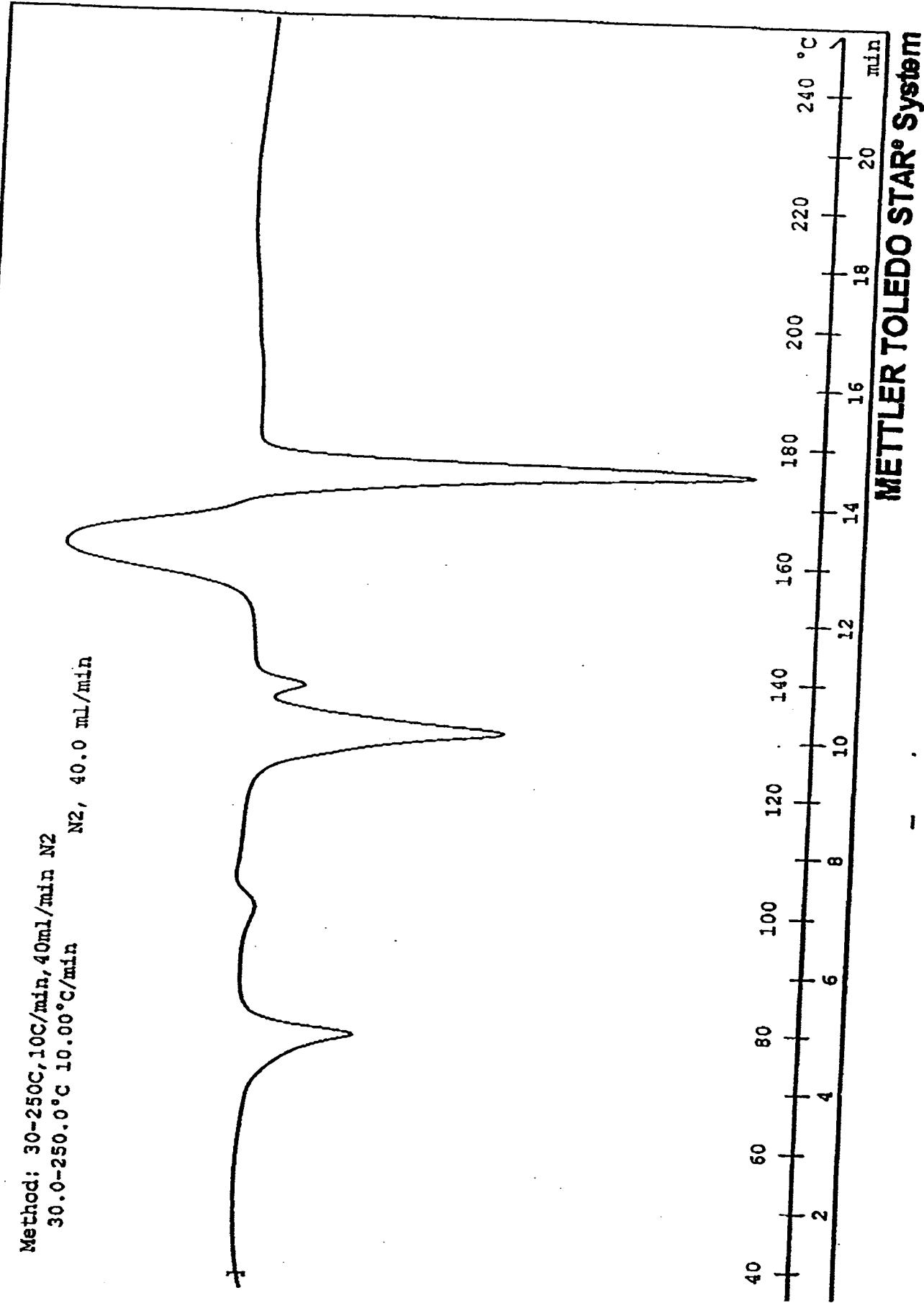


FIGURE #5 U7

Form 6

Method: 30-250C, 10C/min, 40mL/min N2  
30.0-250.0 °C 10.00°C/min  
N2, 40.0 mL/min

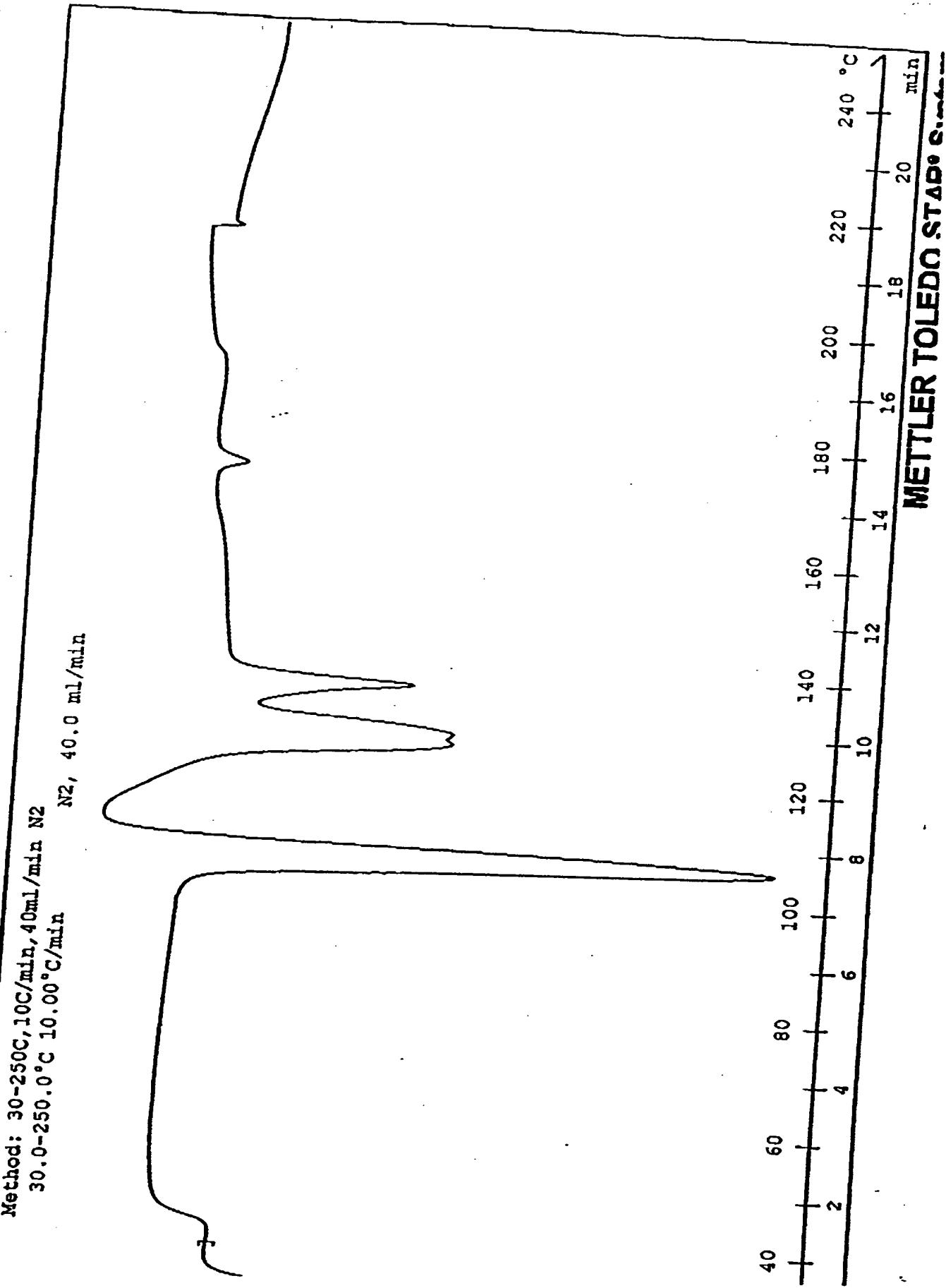


Figure 48  
Form F

Method: 30-250°C, 10C/min, 400ml/min N2  
30.0-250.0°C 10.00°C/min  
N2, 40.0 ml/min

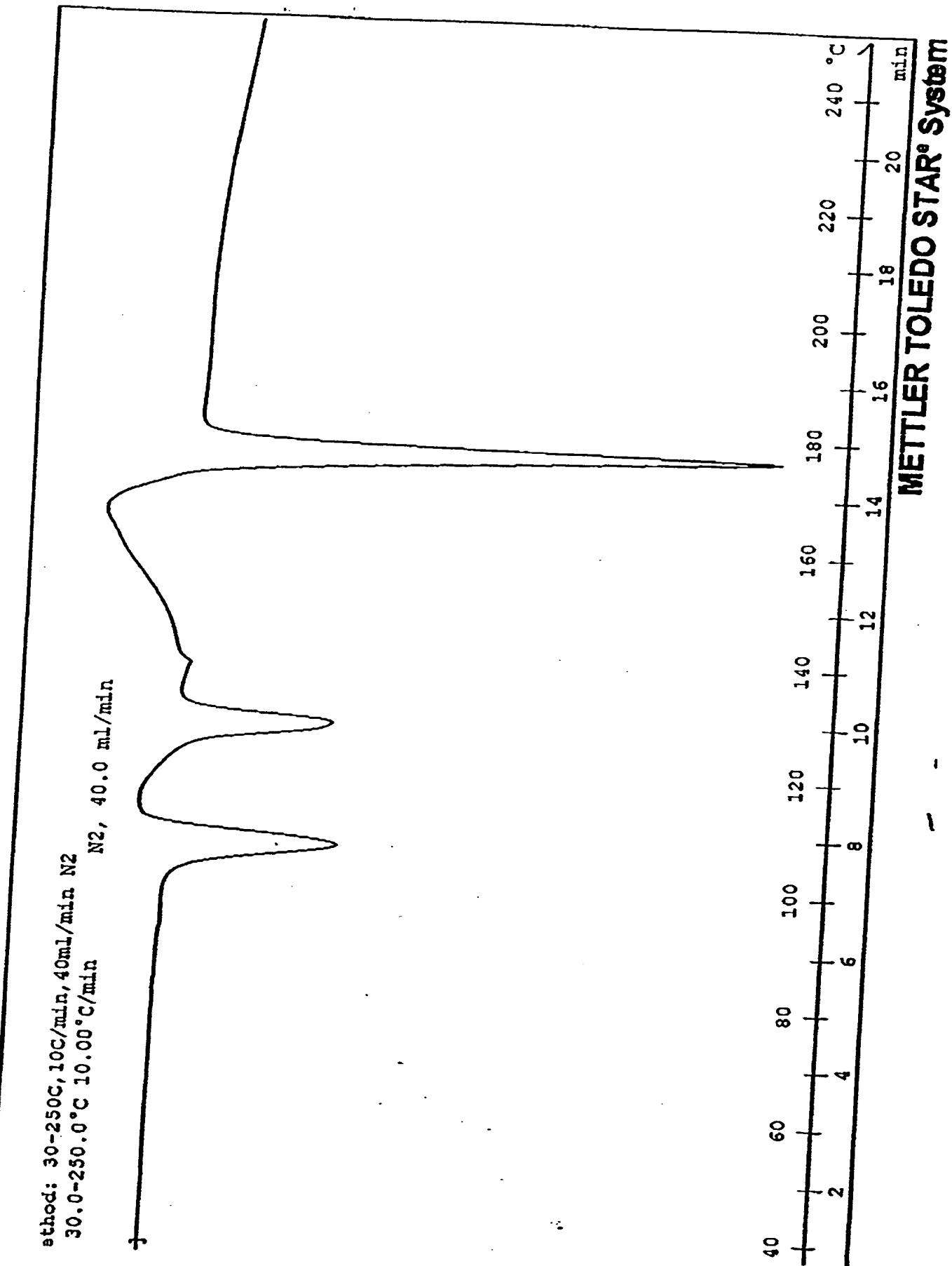


FIGURE 47 40  
Form Q

Method: 30-250C, 10C/min, 40mL/min N2  
30.0-250.0°C 10.00°C/min N2, 40.0 mL/min

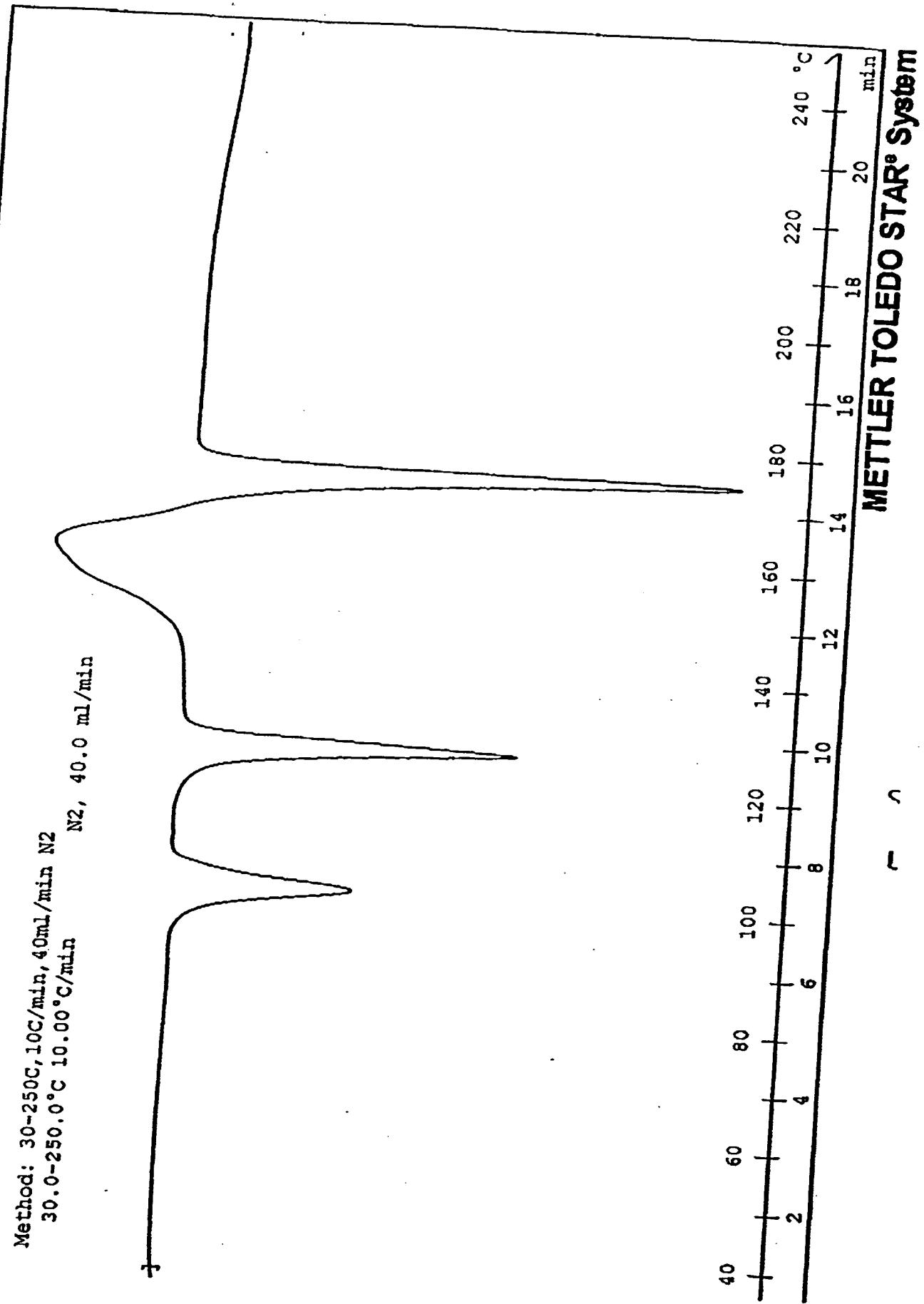


FIGURE 48-50  
Form T

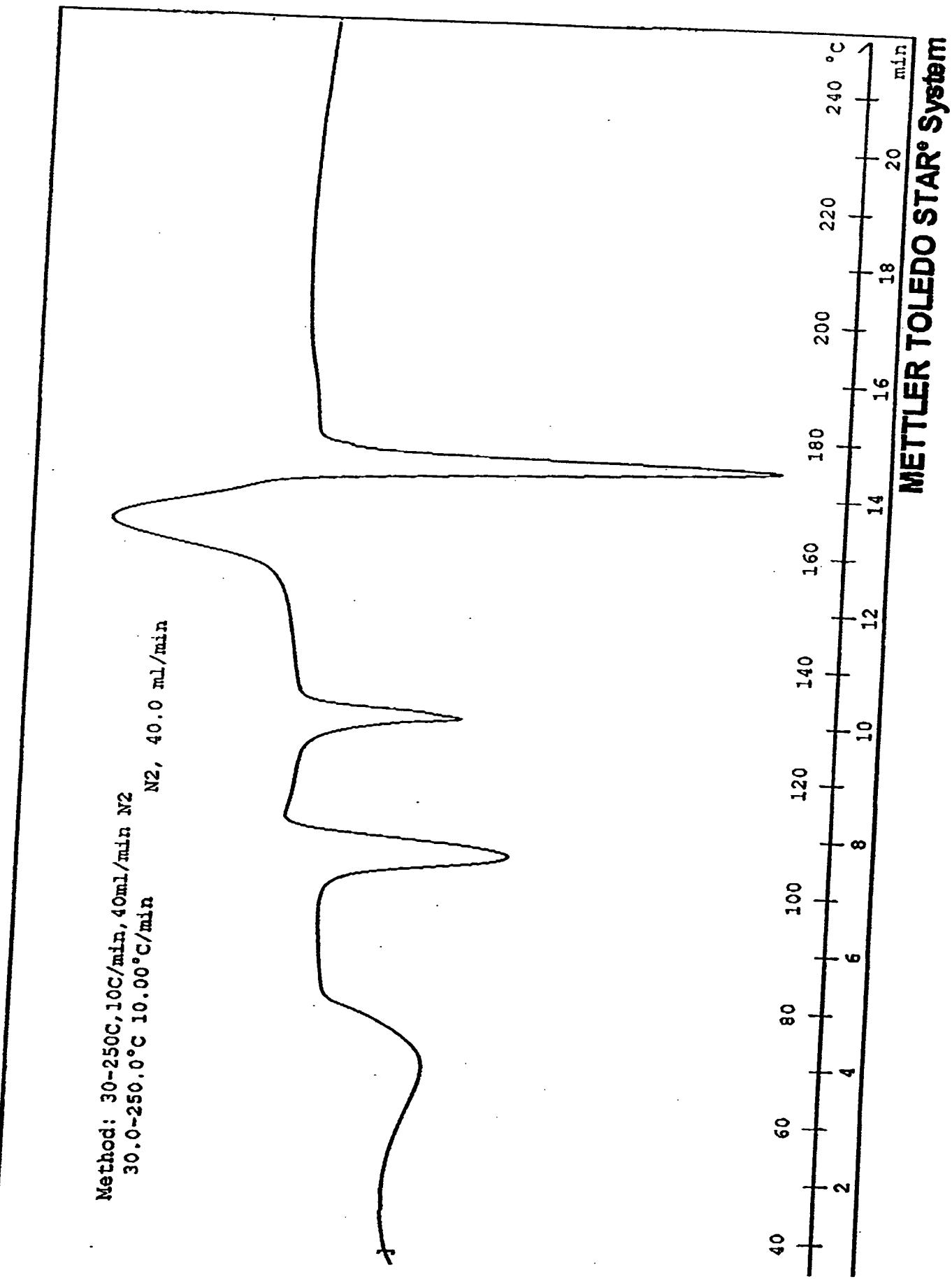


FIGURE 45. 5

Form I $\alpha$

Method: 30-250°C, 10°C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min N2, 40.0 ml/min

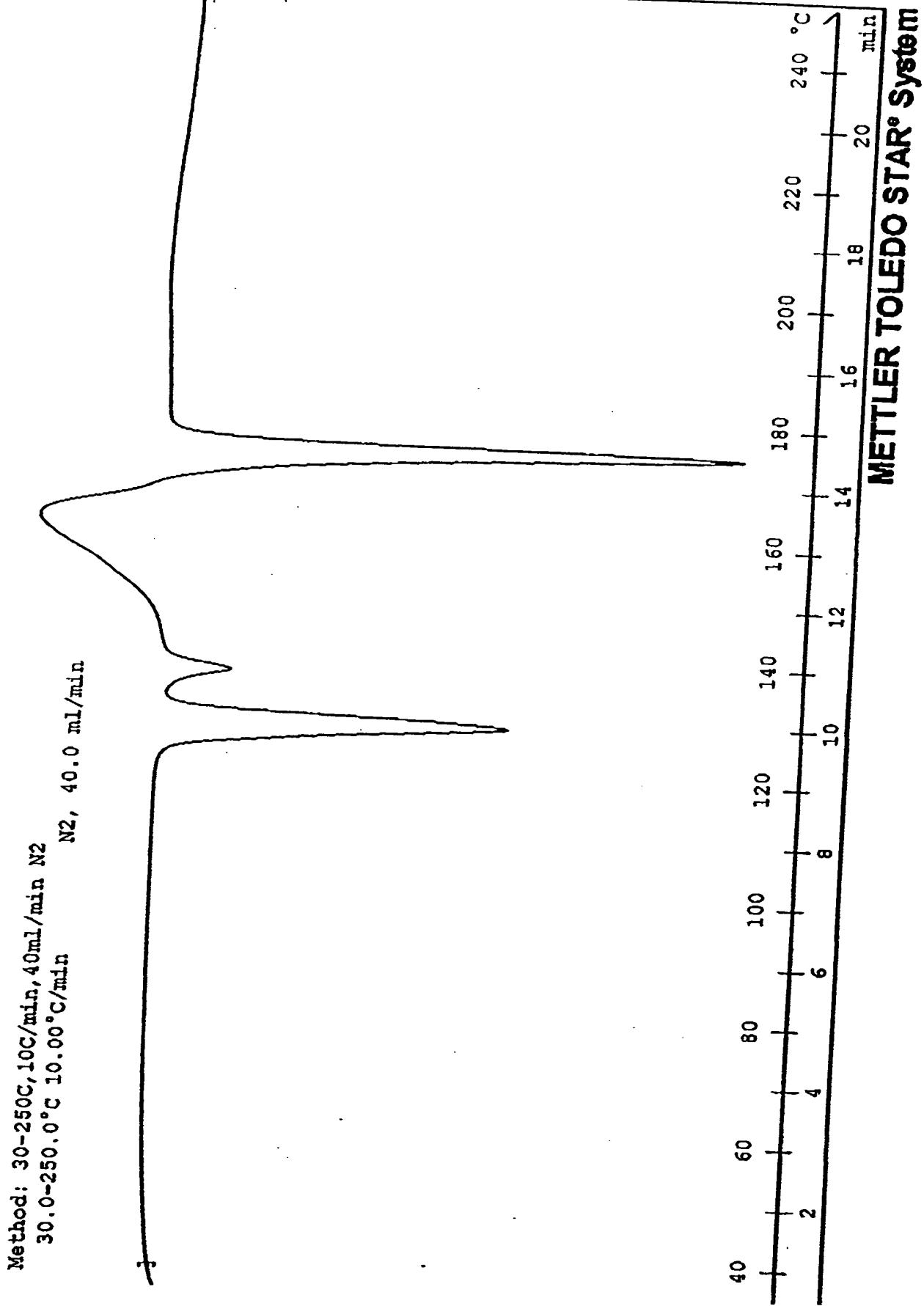
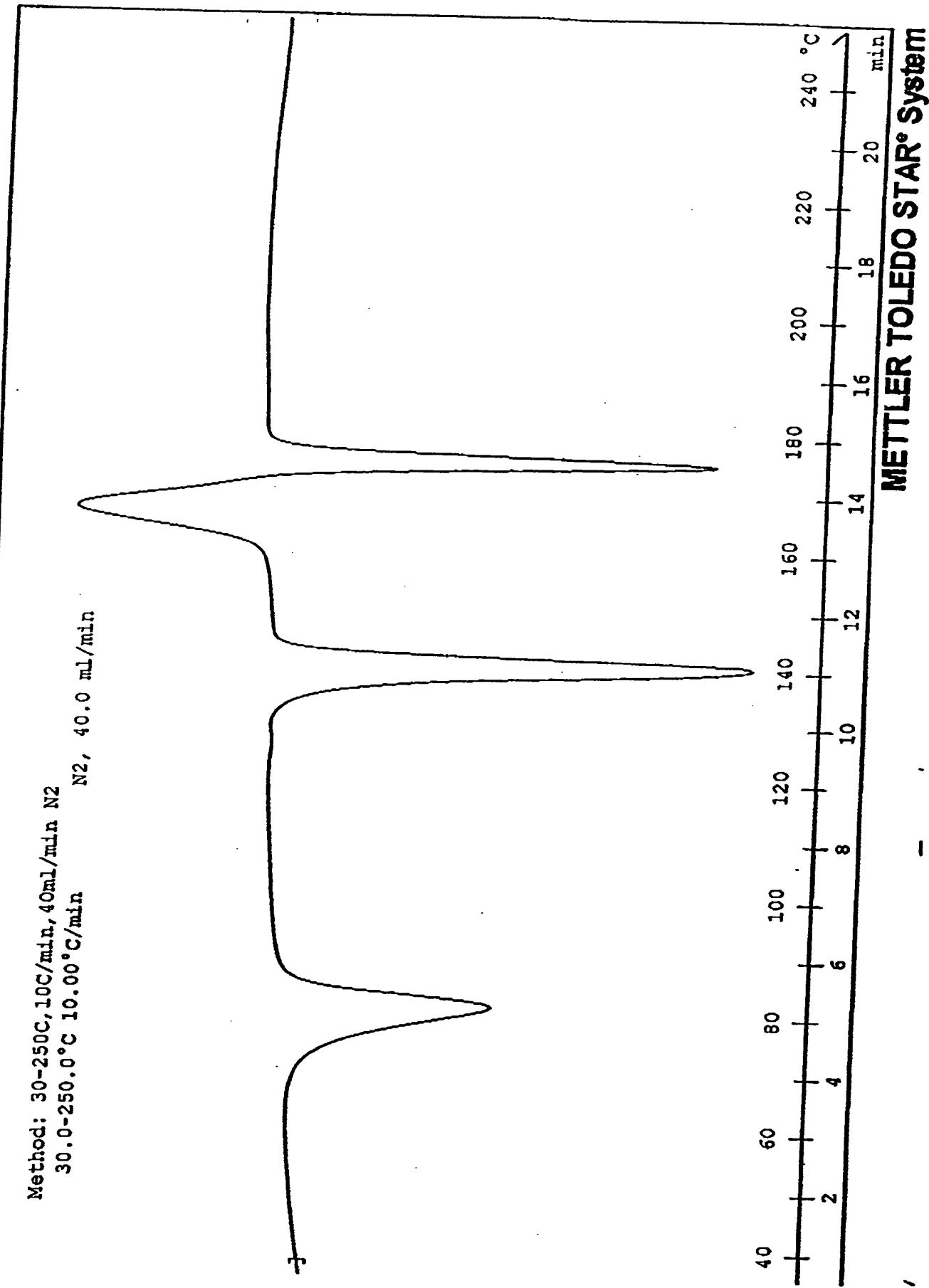


FIGURE 50-2  
Form V

Method: 30-250C, 10C/min, 40mL/min N2  
30.0-250.0°C 10.00°C/min  
N2, 40.0 mL/min



**METTLER TOLEDO STAR® System**

FIGURE 53

Form Y (chloroform solvent)

Method: 30~250°C, 10C/min, 40ml/min N2  
30.0~250.0°C 10.00°C/min N2, 40.0 ml/min

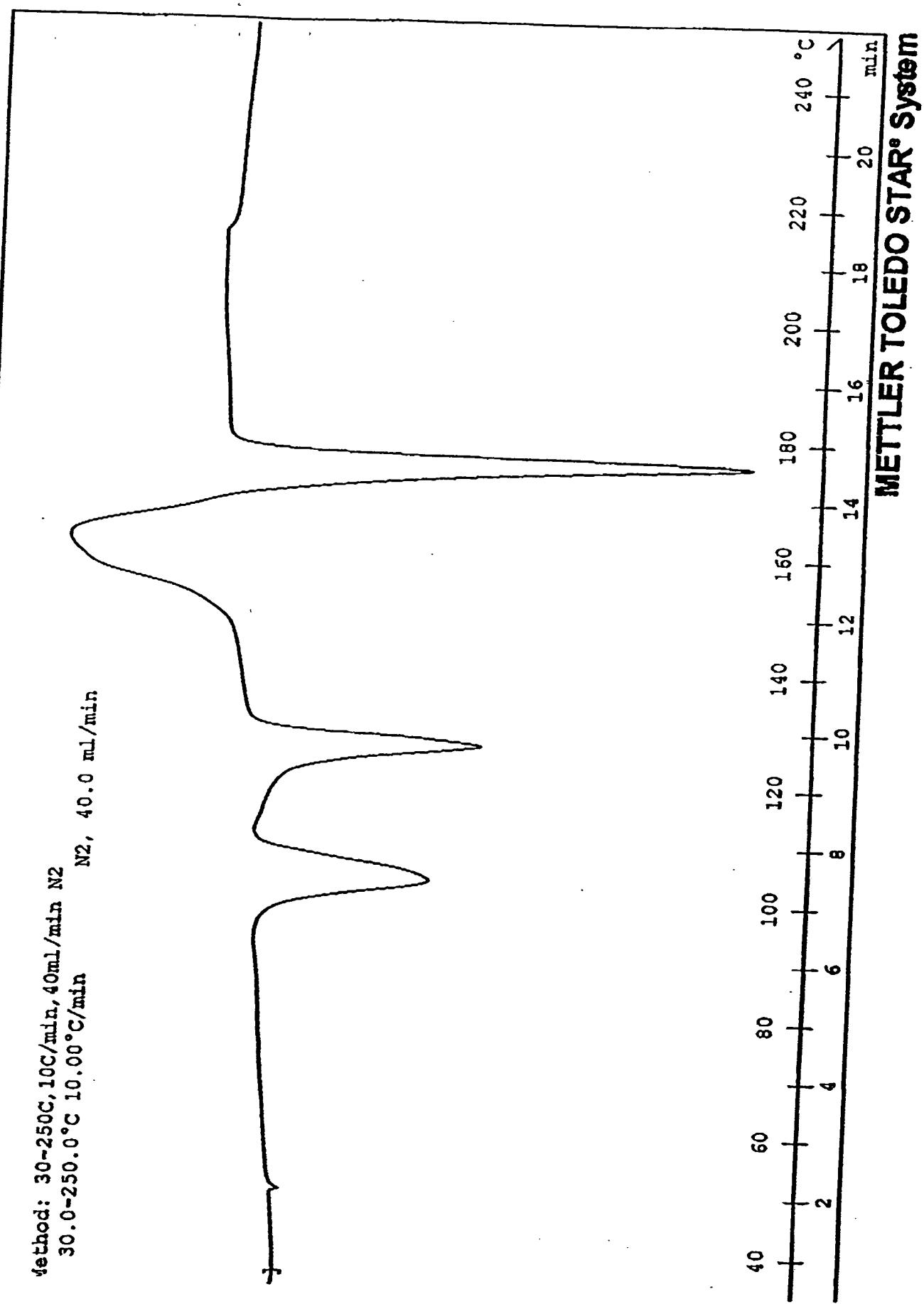
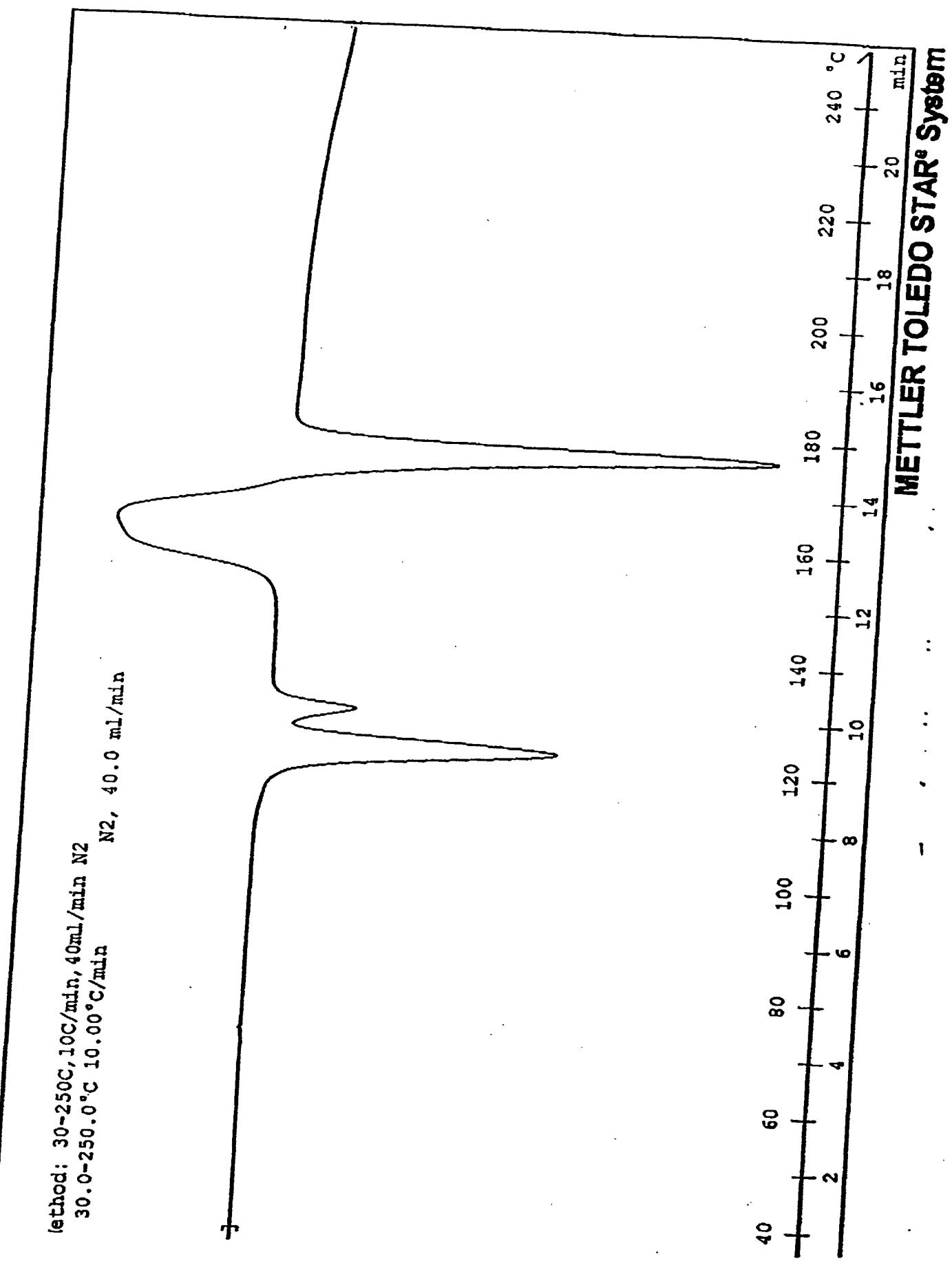


Figure 541  
Y (dichloromethane solution)

Method: 30-250C, 10C/min, 40mL/min N2  
30.0-250.0 °C 10.00 °C/min N2, 40.0 mL/min



55

Figure 27 - Nateglinide Form Z

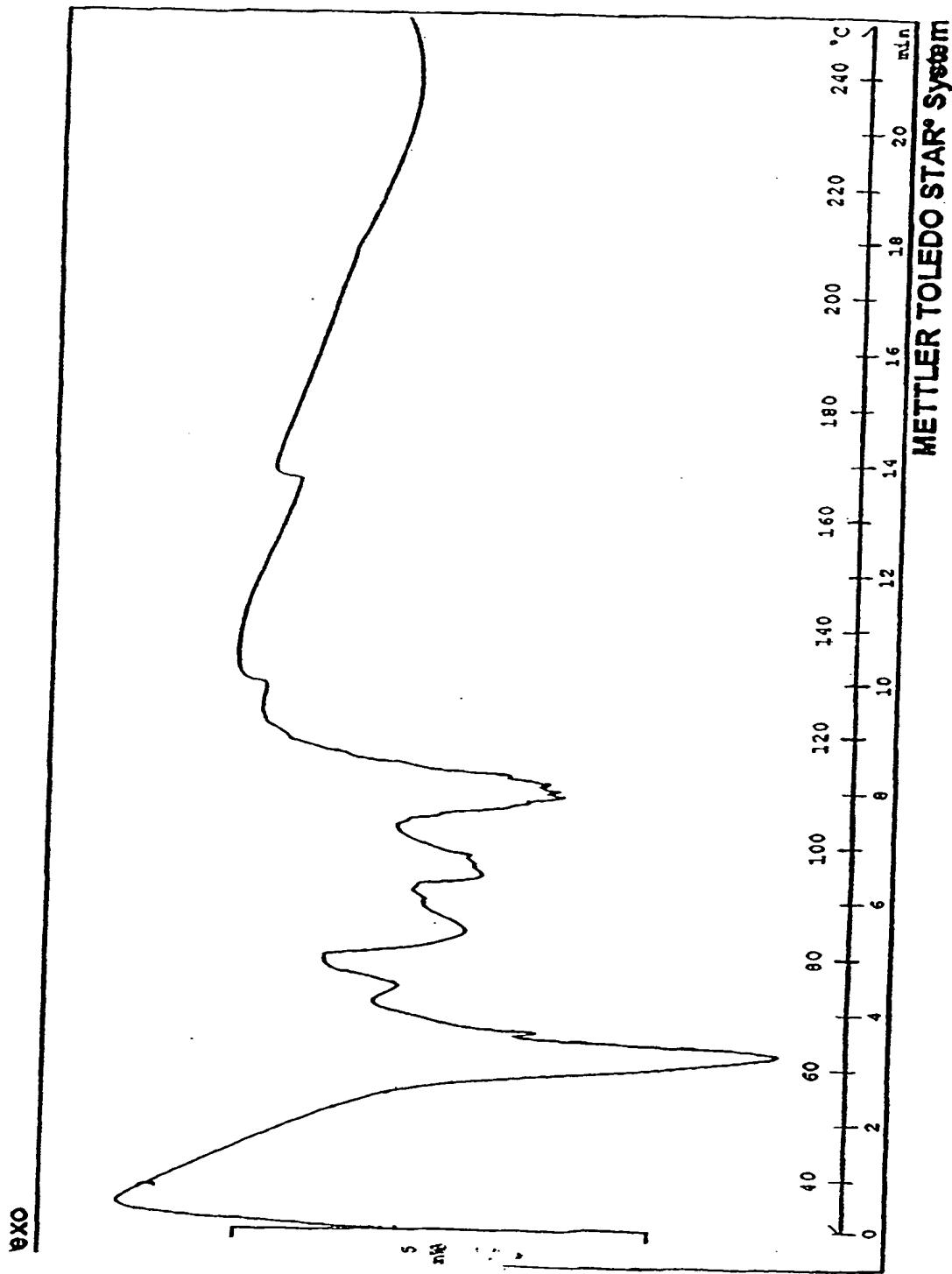


FIGURE 5-56  
Form  $\alpha$

IXO

Method: 30-250C, 10C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min N2, 40.0 ml/min

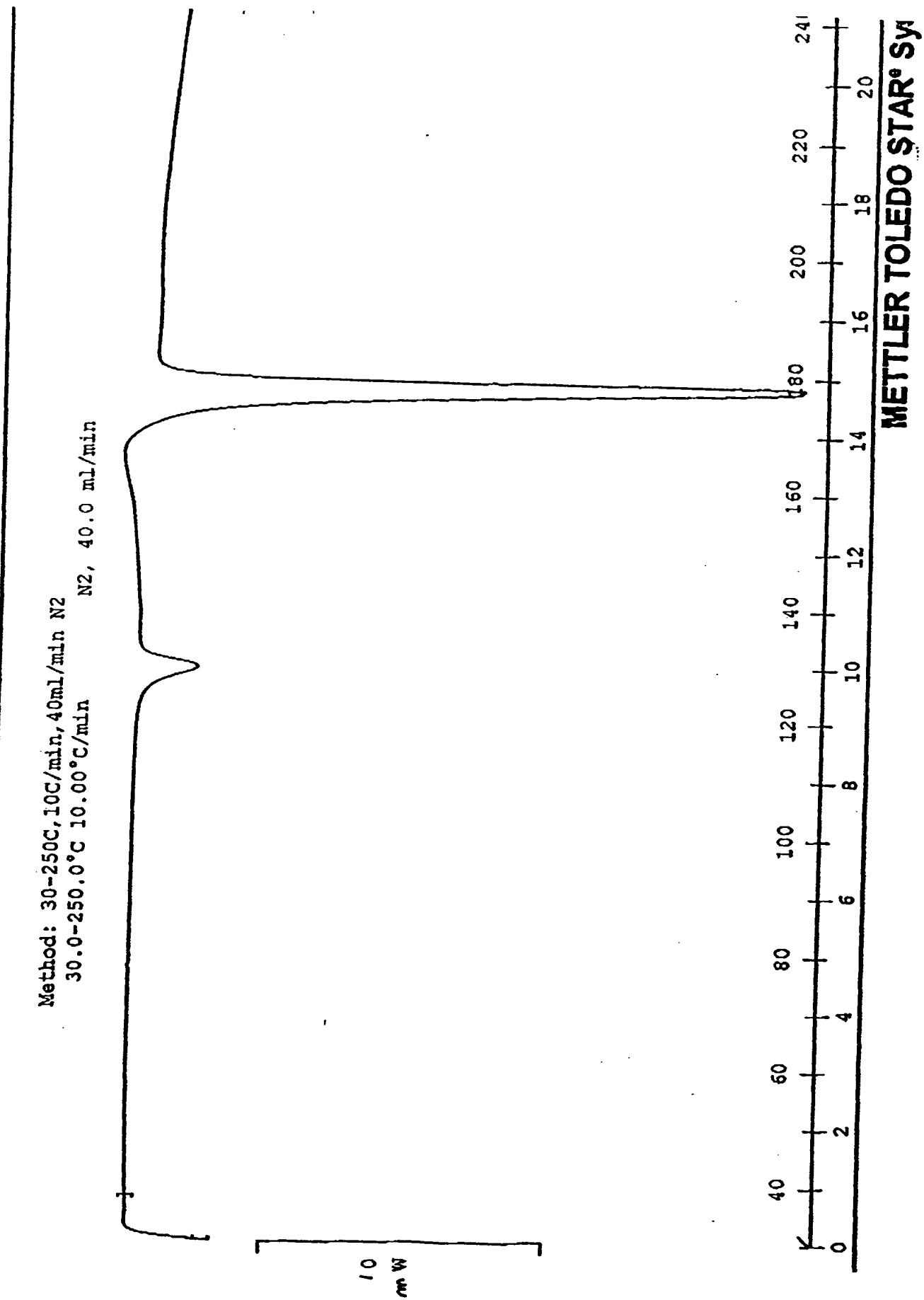
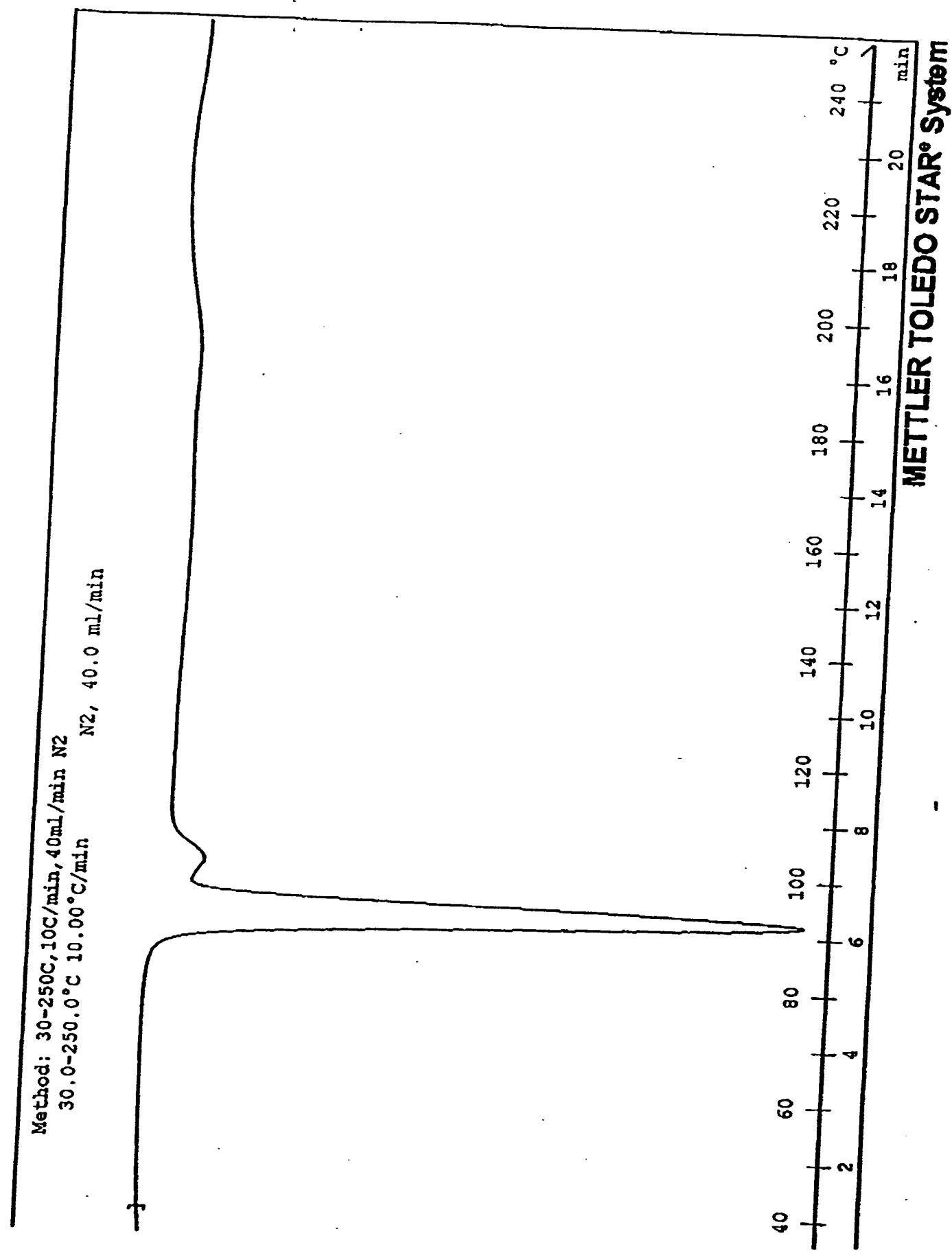


Figure S7  
Form Beta

Method: 30-250°C, 10C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min N2, 40.0 ml/min

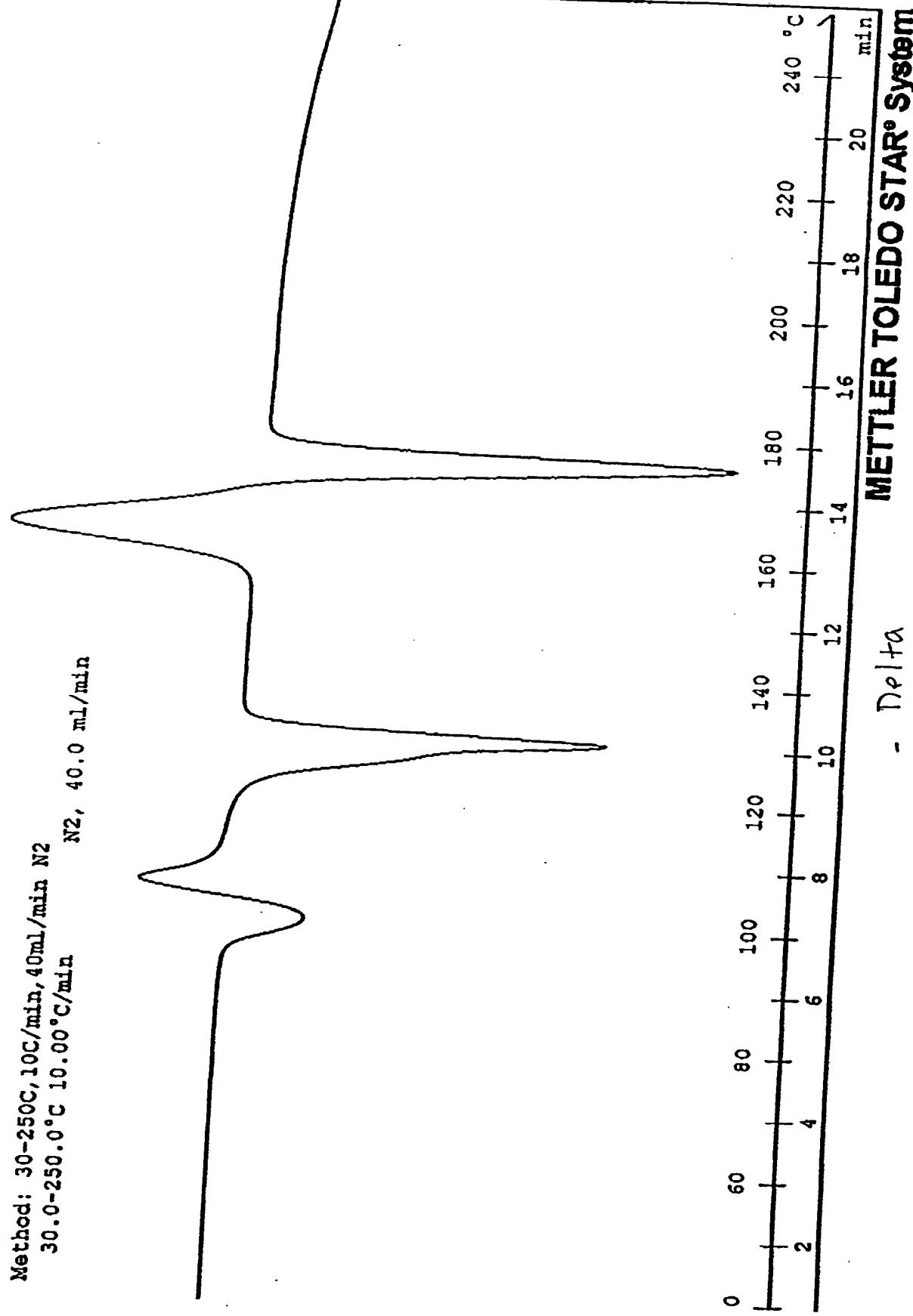


METTLER TOLEDO STAR® System

Form Delta

FIGURE 55-58

Method: 30-250C, 10C/min, 40mL/min N2  
30.0-250.0°C 10.00°C/min N2, 40.0 mL/min



Form Epsilon FIGURE 56-59

Method: 30-250C, 10C/min, 40ml/min N2  
30.0-250.0 °C 10.00 °C/min  
N2, 40.0 mL/min

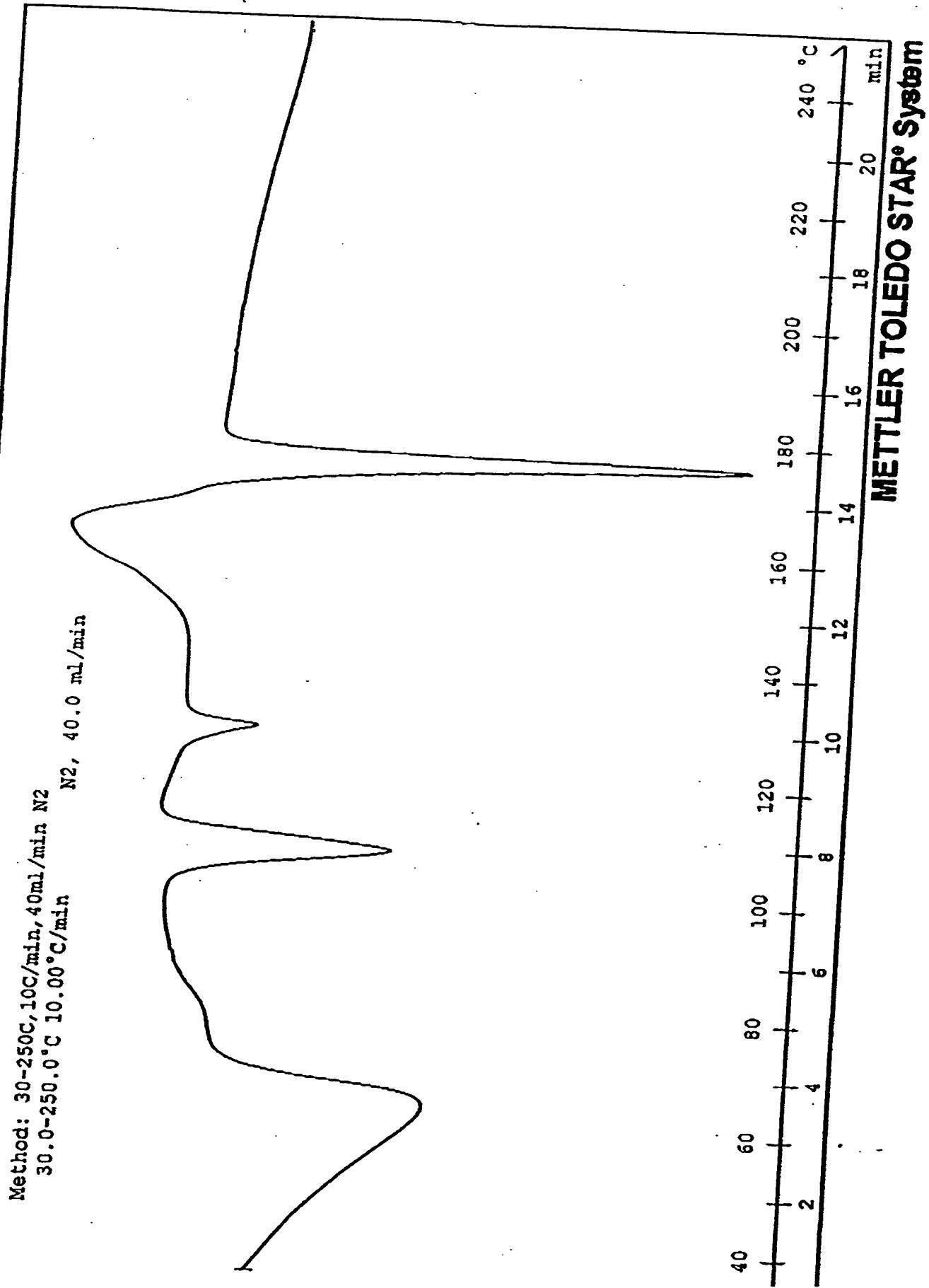


FIGURE 57

Form ~~Gamma~~ Gamma

Method: 30-250°C, 10°C/min, 40mL/min N2  
30.0-250.0°C 10.00°C/min  
N2, 40.0 mL/min

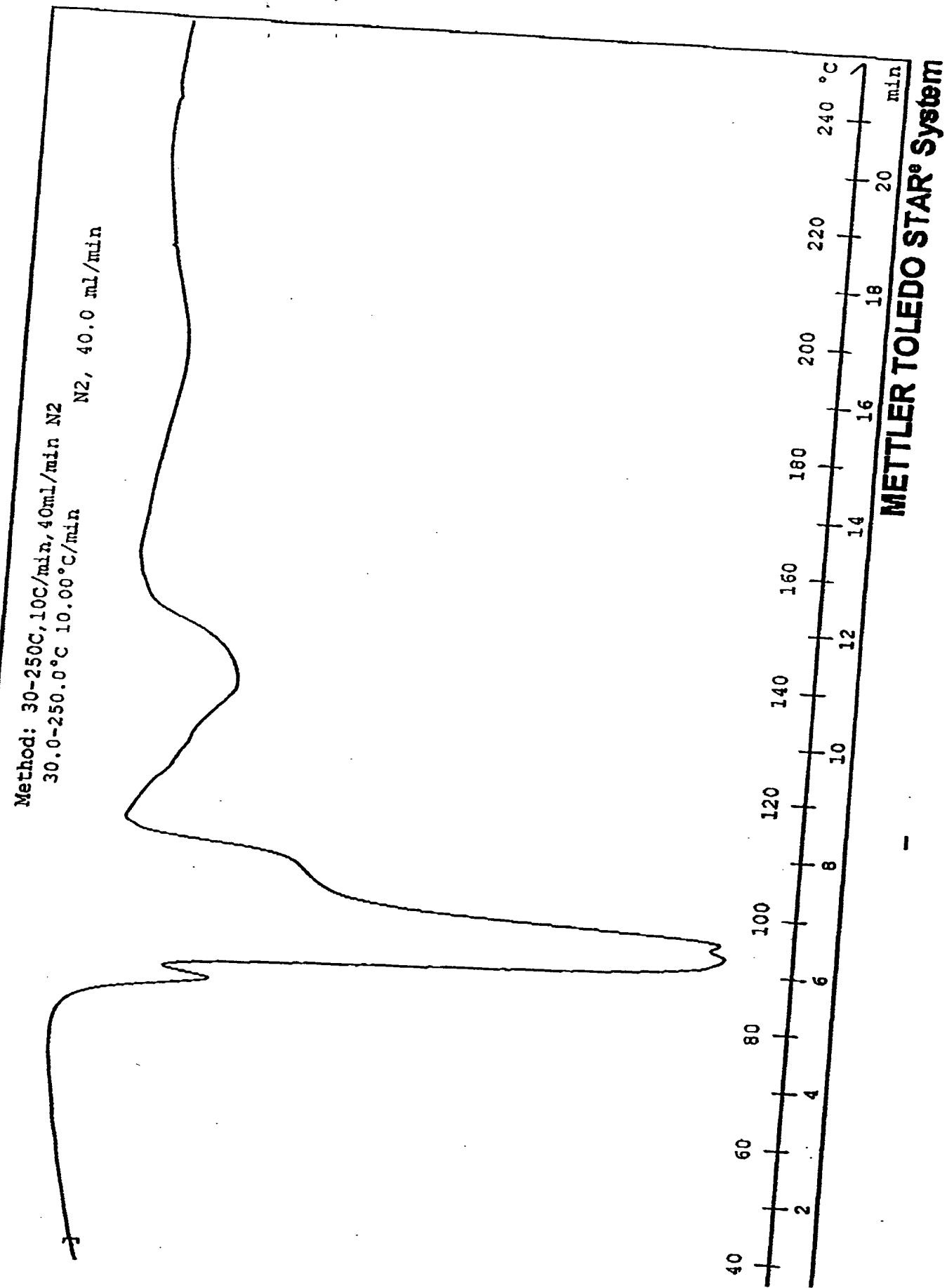


FIG. 6 i Form Sigma  
exo

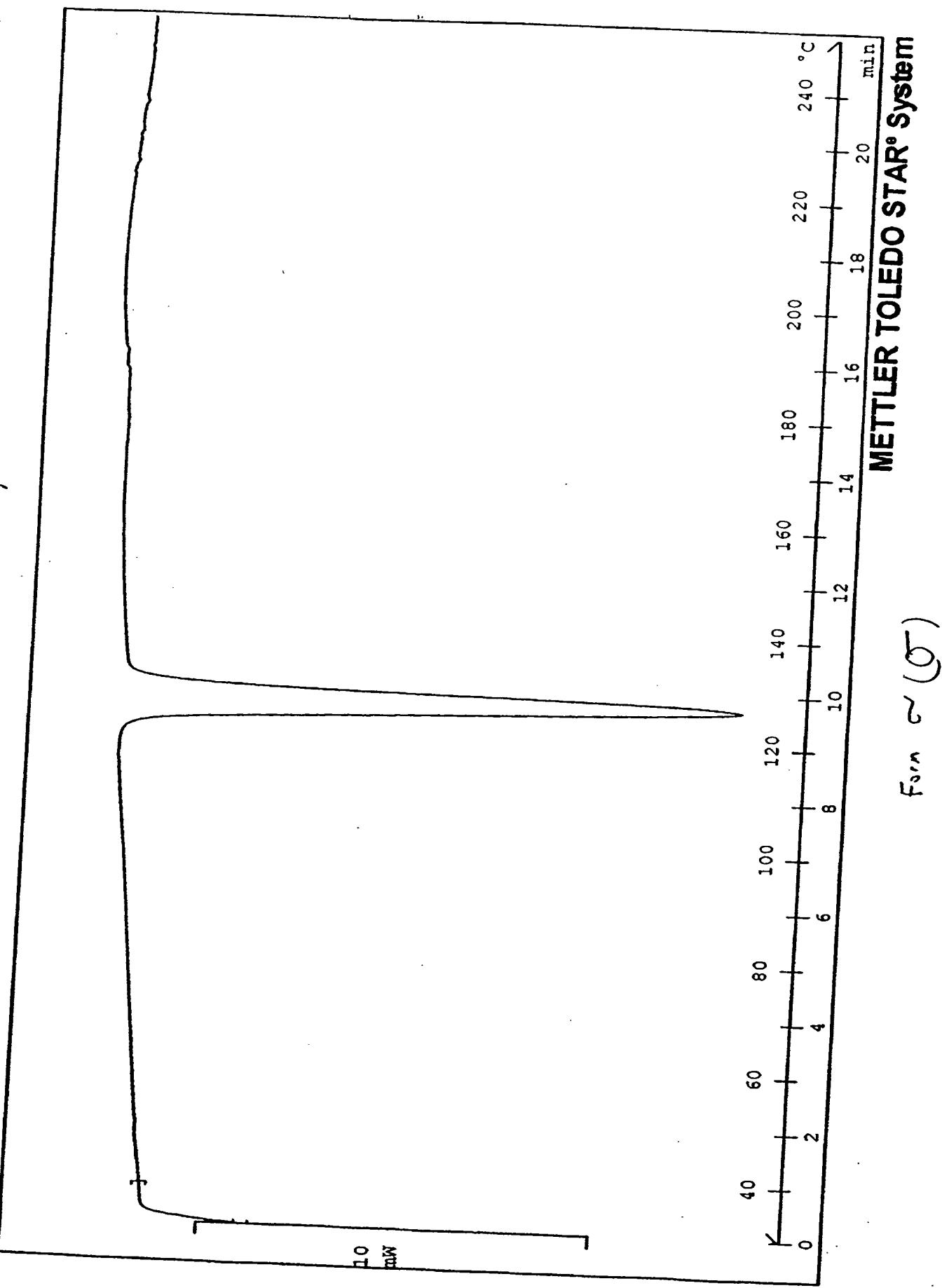


FIGURE 62 Form Theta

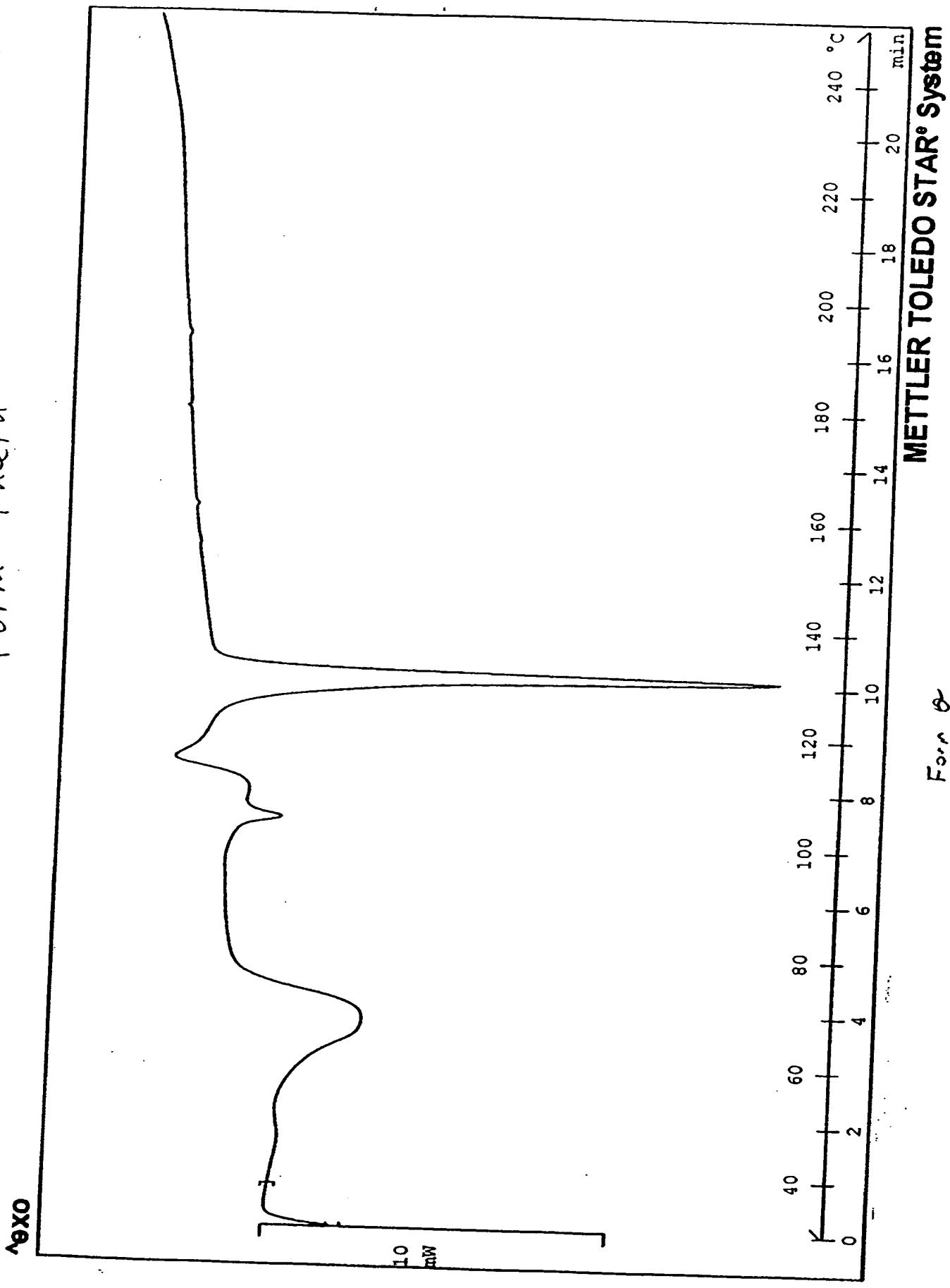


Figure 63

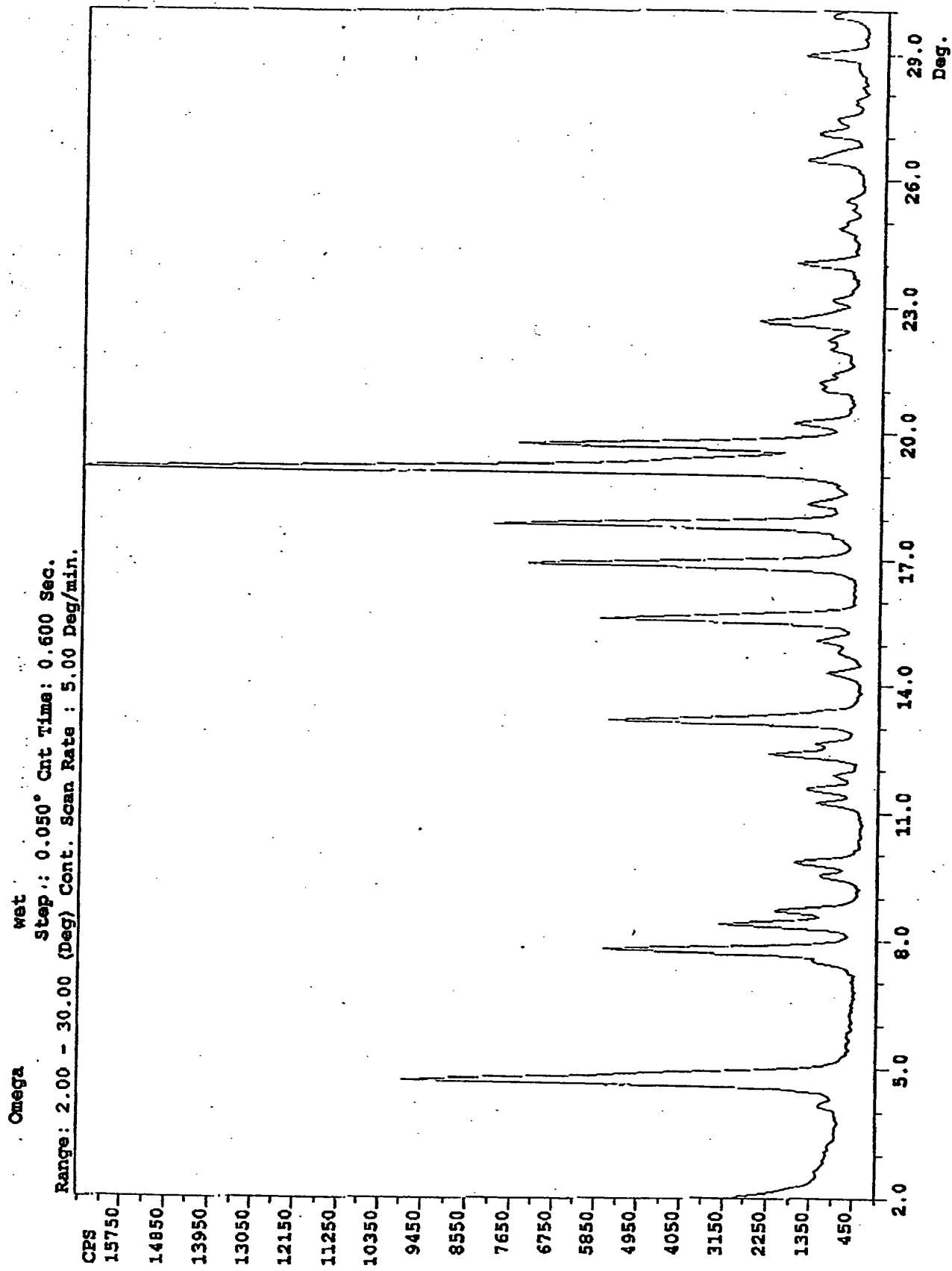


Figure 64

Comparison between the impurity profile of Nateolinide crystallized in IPA-H<sub>2</sub>O and Nateolinide crystallized in Methanol-H<sub>2</sub>O

Sample No	Solvent	Impurity profile by RRT [% w/w]							
		D-PA (0.23)	(0.25)	(0.46)	(0.80)	Ipcha (0.89)	Dimer (1.38)	Methyl Ester (1.51)	Isopropyl Ester (2.3)
RL-2155/1	Methanol-H <sub>2</sub> O	<0.01		0.02	<0.01	0.03	0.02	2.91	0.04
RL-2163/4	IPA-H <sub>2</sub> O	<0.01	0.04		0.02	0.02	0.01		0.03

Note: D-PA means D-Phenyl Alanine

Ipcha means Iso propyl cyclohexyl carboxylic acid

Both are the starting materials of the product

(-)-N-[(trans-4-isopropyl cyclohexane)carbonyl]-D-phenylalanine

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